

COLT OFFICERS ACP AUTOMATIC PISTOL, DRAWINGS AND DIAGRAMS

FIRST EDITION



Drawn and Edited by Harwood W. Loomis

COLT OFFICERS ACP AUTOMATIC PISTOL, DRAWINGS AND DIAGRAMS

First Edition

Author/Editor: Harwood W. Loomis

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HISTORY

The United States Army has for a long time issued special sidearms to general officers. Prior to 1972, these pistols were specially tuned and refinished versions of the Colt Model 1903 and Colt Model 1908 Pocket Hammerless pistols. By 1970, the 1903 and 1908 models were becoming old and obsolete. The U.S. Army's Rock Island Arsenal was charged with developing a suitable replacement. Since at that time the Army's adopted sidearm was the Pistol, Automatic, Caliber .45, M1911A1 pistol, the Rock Island Arsenal team started with standard M1911A1 pistols and modified them to make them more suitable for issue as personal sidearms to generals. The result was designated the Pistol, General Officers', Caliber .45, M15.

The M15 General Officers' Pistol was produced only by the Rock Island Arsenal and only for issue to general officers. With a 4¼-inch barrel and a full-size frame, the M15 General Officers pistol was similar in size and configuration (but different in internal details) to the Colt Commander and Combat Commander pistols. The M15 General Officers' Pistol was produced by Rock Island Arsenal from 1972 through 1984. It is reported that a total of 1,004 were produced.

As the civilian market began to recognize the advantages of smaller handguns that are easier to conceal than full-size, duty sidearms, Colt developed an even smaller version of the 1911. Introduced in 1985, the Colt Officers ACP had a 3½-inch barrel and a grip frame approximately ½ inch shorter than the M1911A1 and the M15 General Officers' Pistol. The then-new Officers ACP was chambered in .45 ACP. It was discontinued in 1997, and was replaced by the 3-inch Defender model.

THIS BOOK

Scans of the official U.S. Government "blueprints" (which are, technically, black line prints rather than blueprints) can be found on various sites across the Internet, and copies can be obtained from the U.S. Army. However, because the Colt Officers ACP is a proprietary product of Colt's Manufacturing Company, LLC, and was never produced under Government contract, the engineering drawings for the Officers ACP are Colt's proprietary property and are not available in the public domain. People often wonder how the Officers ACP differs from the M1911A1 and from the similarly-named M15 General Officers Pistol. This compilation of all new drawings is my attempt at answering this question.

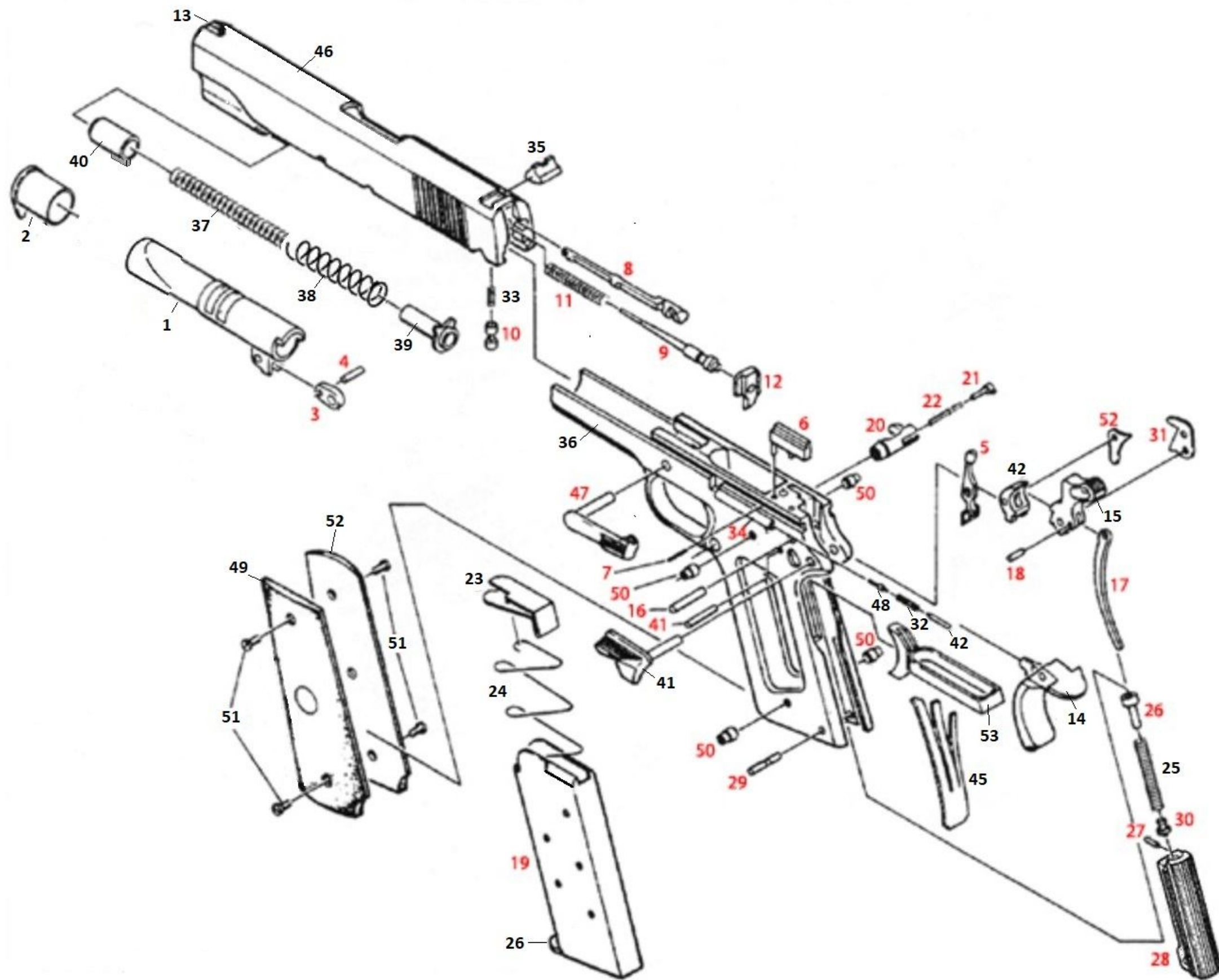
Because no official drawings for the Officers ACP are available, all drawings on the following pages have been produced by the author/editor by referring to copies of the Government drawings for the M1911A1 and then comparing those drawings with measurements taken from physical examples of Colt Officers ACP pistols made available to the author/editor. These drawings are offered for use as reference material only. While the author/editor has made every effort to make these drawings as accurate as possible, subject to the limitations inherent in reverse engineering, the author/editor does not make any representation that the drawings in this set are sufficiently accurate or precise to be used to machine a functional and safe firearm.

CONDITION OF SALE AND USE OF MATERIALS FOUND, PROVIDED, AND / OR SOLD IN THIS PUBLICATION: The information contained in this collection of drawings is provided to the reader solely for his or her amusement, curiosity, education, and historical interest. These drawings represent the author's best efforts to reverse engineer detailed drawings from reproductions of various generations of United States Ordnance Department prints for the full-sized M1911A1 pistol, supplemented by physical measurements taken from multiple samples of Colt Officers ACP pistols. The author assumes no responsibility or liability for the correctness and accuracy of this information. Any other use of this information may be subject to a variety of applicable laws and regulations and is the sole responsibility of those who choose to use it. The government drawings used as source documents are "obsolete" — the U.S. government does not know whether they are accurate or not — the people who did know are long-ago dead from old age! Therefore, the author does not know either! Any attempt to use the drawings provided in this book to build, modify, or use any firearm could potentially be dangerous, and may violate federal, state, or local law. The author and the publisher assume no responsibility for the accuracy of this information, or for the accuracy of the drawings provided herein.

COLT OFFICERS ACP AUTOMATIC PISTOL
DRAWINGS AND DIAGRAMS

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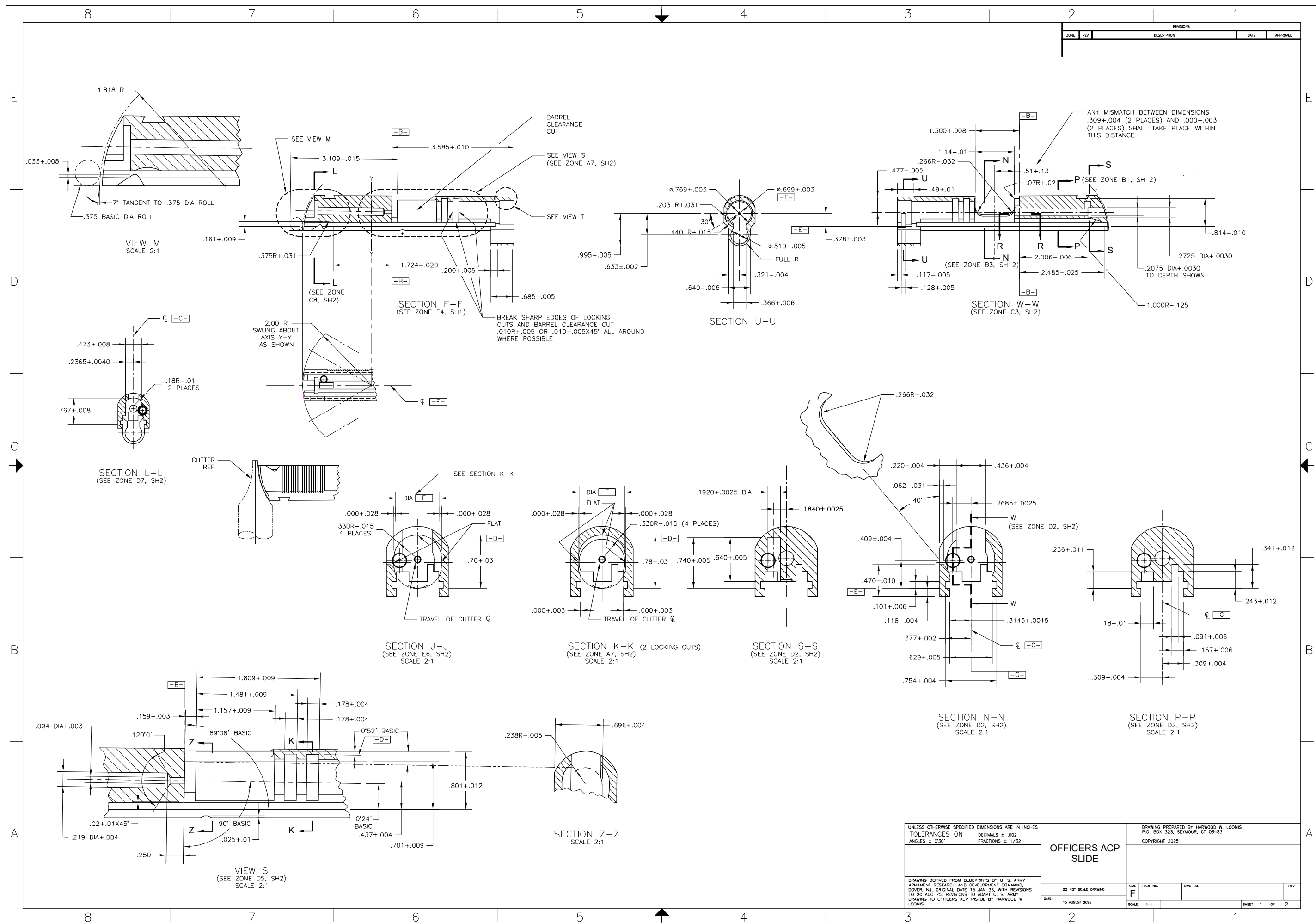
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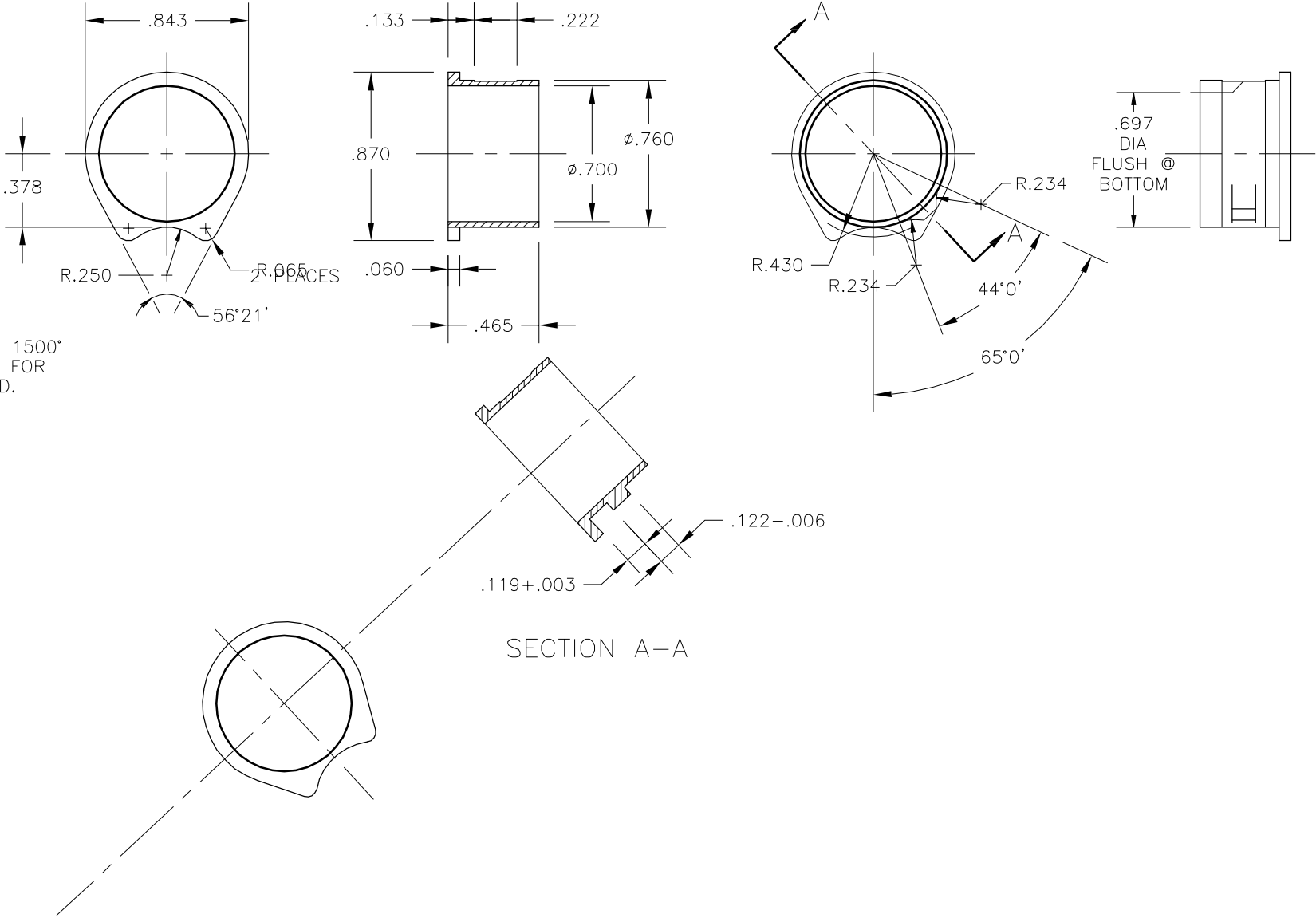
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ± 0°30'		COLT OFFICERS ACP EXTERIOR VIEWS		DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS		DO NOT SCALE DRAWING		SIZE C	FSCM NO.	DWG NO.	REV
		DATE: 15 AUGUST 2025	SCALE 1:1			SHEET 1	OF 1



NOTES:

1. FINISH $125/\sqrt{\text{ALL OVER}}$.
2. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .0015 INCH.
3. ALL EDGES SHALL BE BROKEN .005 + .010
4. MATERIAL:
 - A. STEEL, SAE 1060 THRU 1080, OR SAE 4140, ASTM A575, A576, OR ASTM A108.
 - B. INVESTMENT CASTING IC4140 SPEC MIL-S-22141.
5. HEAT TREATMENT:
 - A. STEEL, SAE 1060 THRU 1080, OR SAE 4140, ASTM A575, A676, OR ASTM A108 AUSTEMPER ALTERNATE: HEAT AT 1450° TO 1500° F, OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED.
 - B. INVESTMENT CASTING IC4140, AUSTEMPER ALTERNATE: HEAT AT 1500° TO 1550°. OIL QUENCH. TEMPER FOR 1 HOUR TO HARDNESS SPECIFIED.
6. MIL-W-13855 APPLIES.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

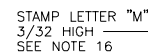
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ROCK ISLAND ARSENAL REVISIONS TO 10 FEB 75.
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**BUSHING,
BARREL**

DRAWING PREPARED BY HARWOOD W. LOOMIS
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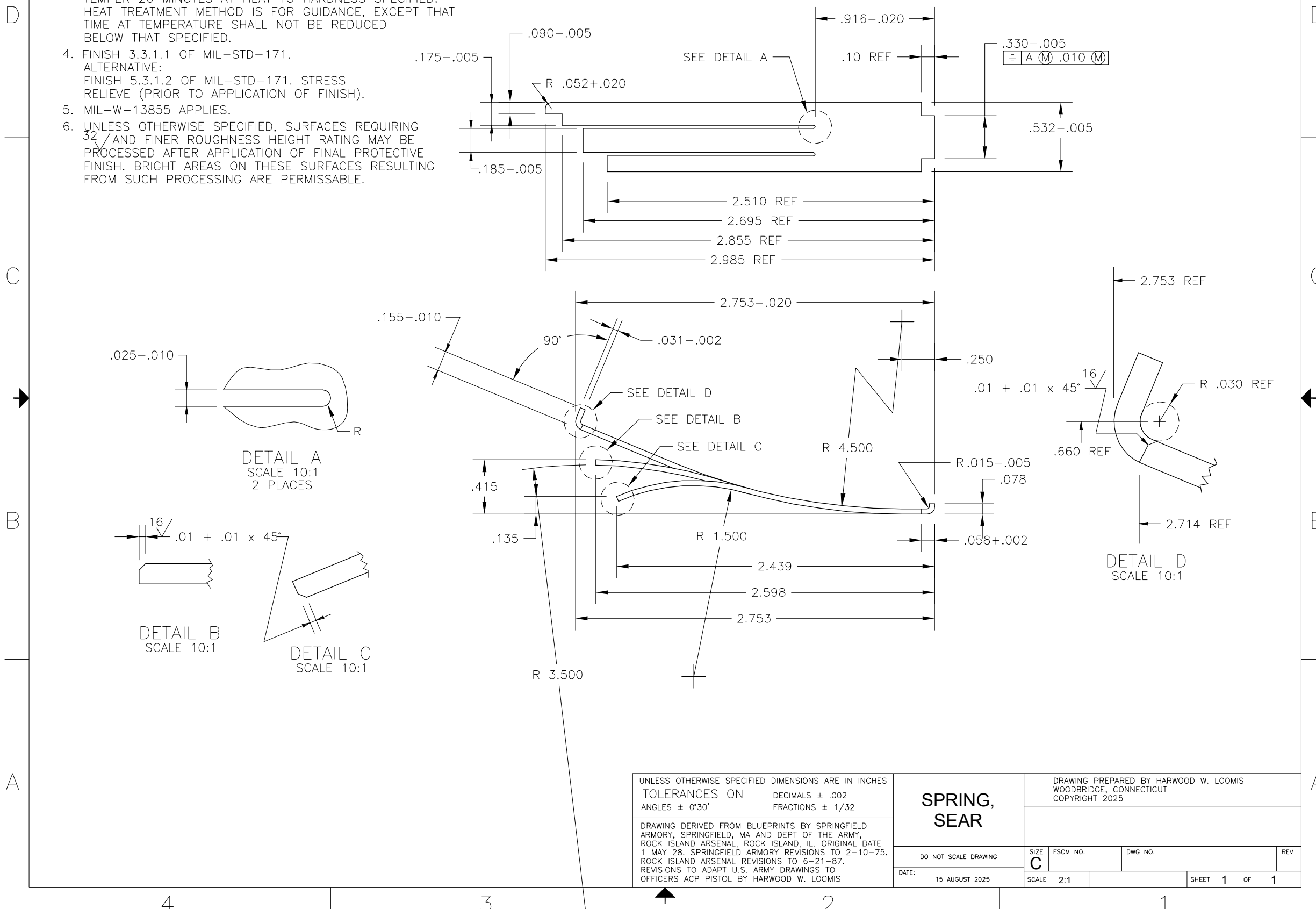


BARREL

NOTES:

1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED
2. MATERIAL: STEEL, SAE 1055 THRU 1075 - ASTM A684
3. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINISH 3.3.1.1 OF MIL-STD-171. ALTERNATIVE: FINISH 5.3.1.2 OF MIL-STD-171. STRESS RELIEVE (PRIOR TO APPLICATION OF FINISH).
5. MIL-W-13855 APPLIES.
6. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING $32\sqrt{\text{ }}$ AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS ON THESE SURFACES RESULTING FROM SUCH PROCESSING ARE PERMISSABLE.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/32

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. SPRINGFIELD ARMORY REVISIONS TO 2-10-75. ROCK ISLAND ARSENAL REVISIONS TO 6-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

SPRING,
SEAR

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
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DO NOT SCALE DRAWING

DATE: 15 AUGUST 2025

SIZE

C

FSCM NO.

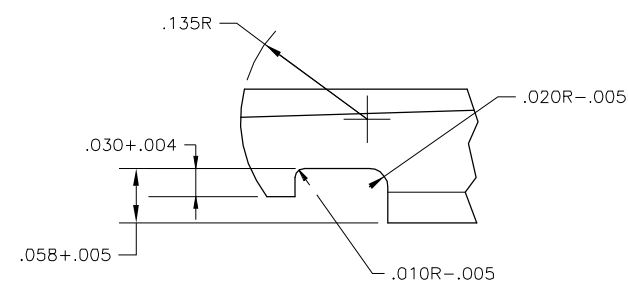
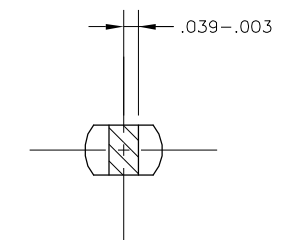
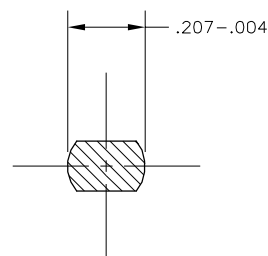
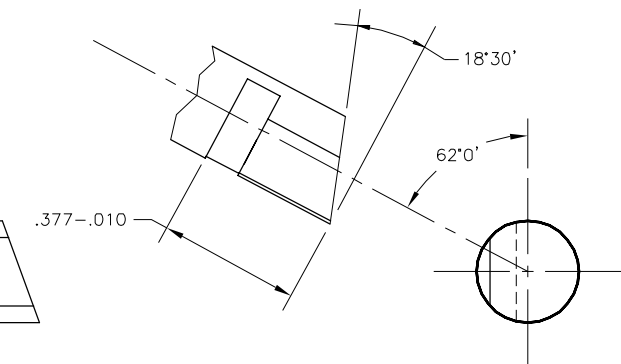
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SCALE 2:1

SHEET 1 OF 1

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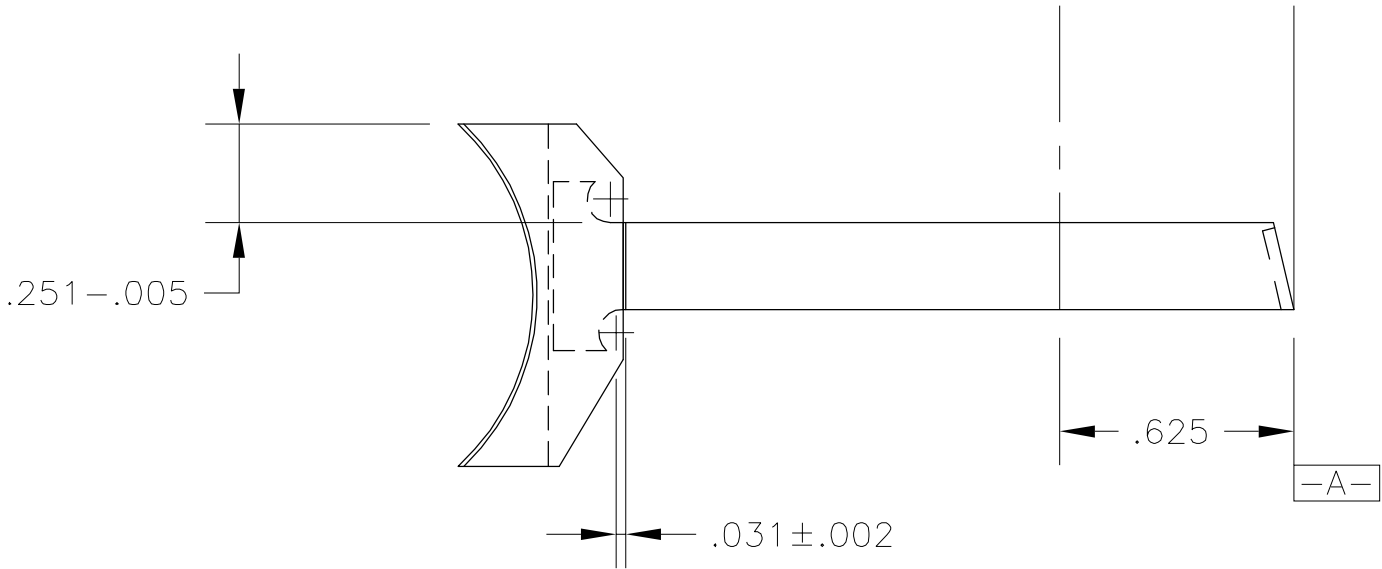
A

DETAIL E
SCALE 10:1

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NOTES:

- 1. HEAT TREATMENT: CARBURIZE FOR DISTANCE -A- TO CASE DEPTH .002 TO .005. OIL QUENCH. TEMPER TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
- 2. MIL-W-13855 APPLIES.



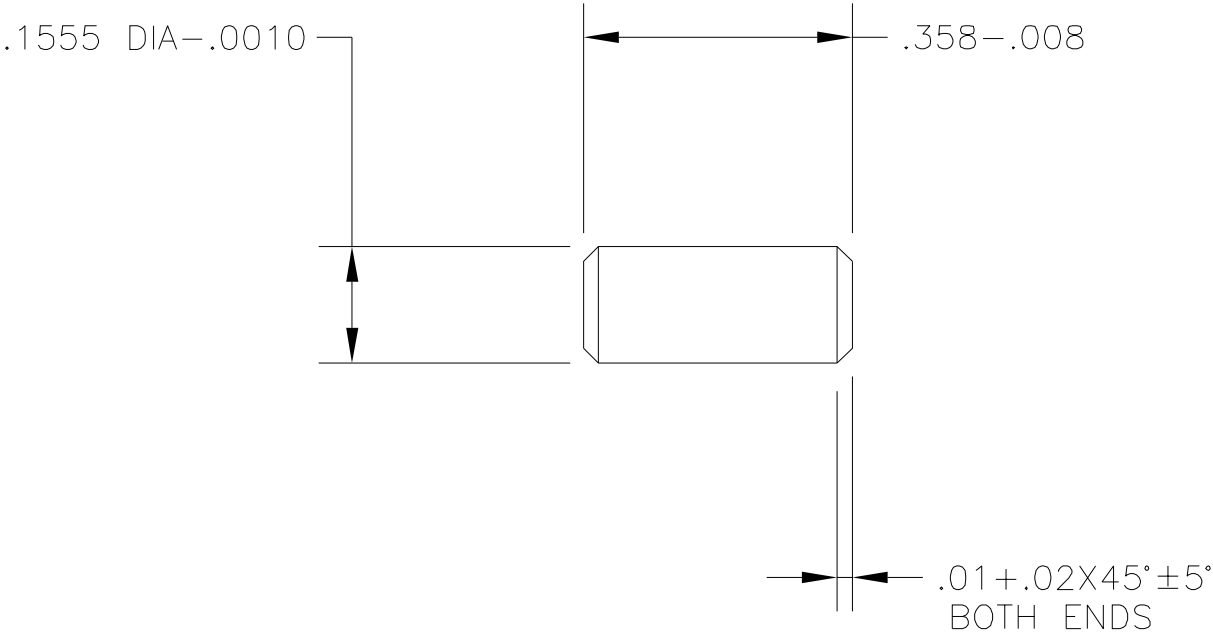
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32 ANGLES ± 0°30'	TRIGGER ASSEMBLY	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT				
		COPYRIGHT 2025				
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.		REV
	DATE: 15 AUGUST 2025	SCALE 2:1			SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.2.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

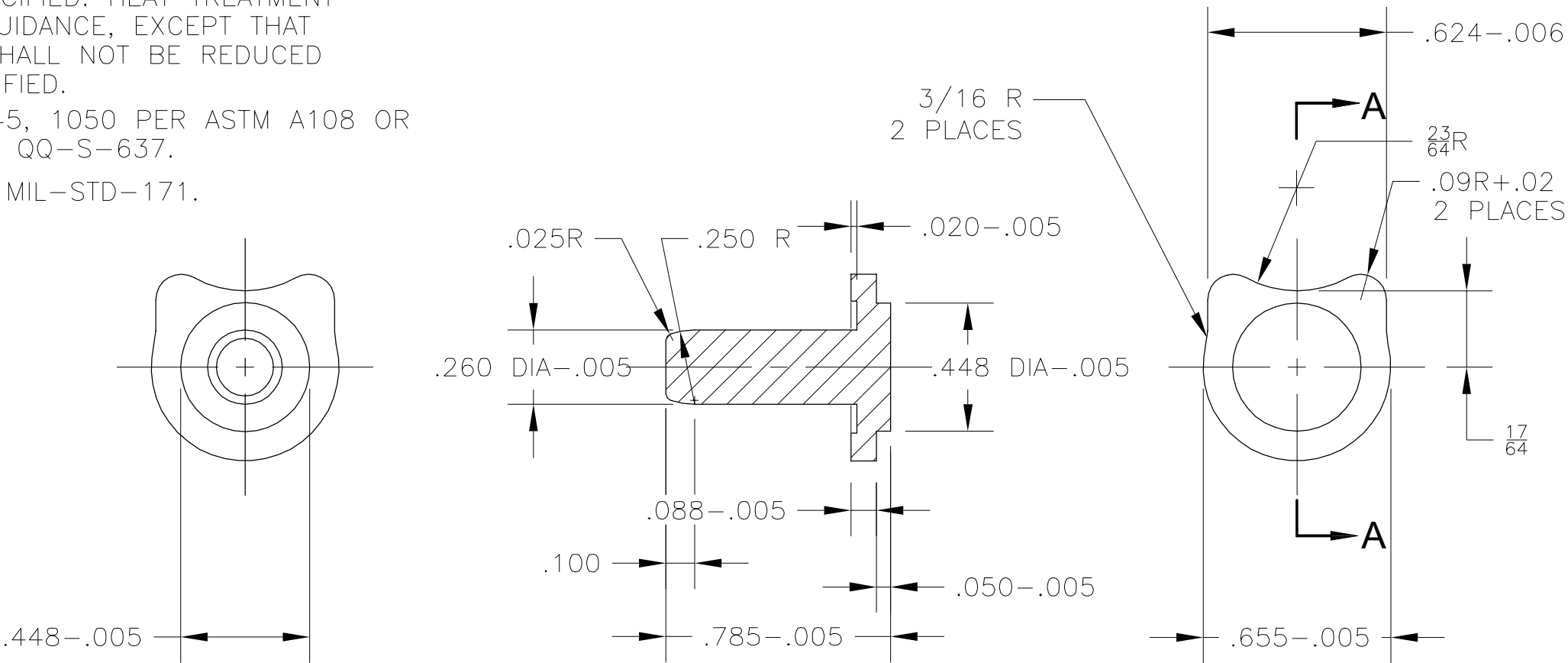


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/64	PIN, BARREL LINK	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE 4:1			SHEET 1 OF 1

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
- 3. HEAT TREATMENT: HEAT AT 1500° TO 1550° F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 4. STEEL, CMPSN 1045, 1050 PER ASTM A108 OR CMPSN 1137, PER QQ-S-637.
- 5. FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



SECTION A-A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/32		GUIDE, RECOIL SPRING		DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS							
DO NOT SCALE DRAWING		SIZE B	FSCM NO.		DWG NO.		REV
DATE: 15 AUGUST 2025		SCALE 2:1				SHEET 1 OF 1	



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

WIRE DIAMETER ----- .043
COIL DIAMETER (OO) ----- .430+.005
FREE LENGTH ----- 3.75 REF
ACTIVE COILS ----- 15
TOTAL COILS ----- 16
DIRECTION OF HELIX ----- R H
LOAD AT COMPRESSED LENGTH OF 2.67 ----- 4.45 LB±0.50 LB
LOAD AT COMPRESSED LENGTH OF 1.00 ----- 13.30 LB±0.50 LB
SPRING RATE ----- 5.35 LB/IN
SOLID LENGTH ----- .688
TYPE OF ENDS ----- ONE END CLOSED

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY ---- .448 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY -- .336 MAX
MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,
TYPE I, GRADE A



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64	SPRING, RECOIL, OUTER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT			
		COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE			SHEET 1 OF 1





REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

WIRE DIAMETER ----- .033
COIL DIAMETER (OO) ----- .330+.005
FREE LENGTH ----- 3.50 REF
ACTIVE COILS ----- 19
TOTAL COILS ----- 20
DIRECTION OF HELIX ----- L H
LOAD AT COMPRESSED LENGTH OF 2.67 ---- 2.05 LB±0.50 LB
LOAD AT COMPRESSED LENGTH OF 1.00 ---- 9.15 LB±0.50 LB
SPRING RATE ----- 4.25 LB/IN
SOLID LENGTH ----- .660
TYPE OF ENDS ----- ONE END CLOSED

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY ---- .340 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY-- .260 MAX*
MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,
TYPE I, GRADE A

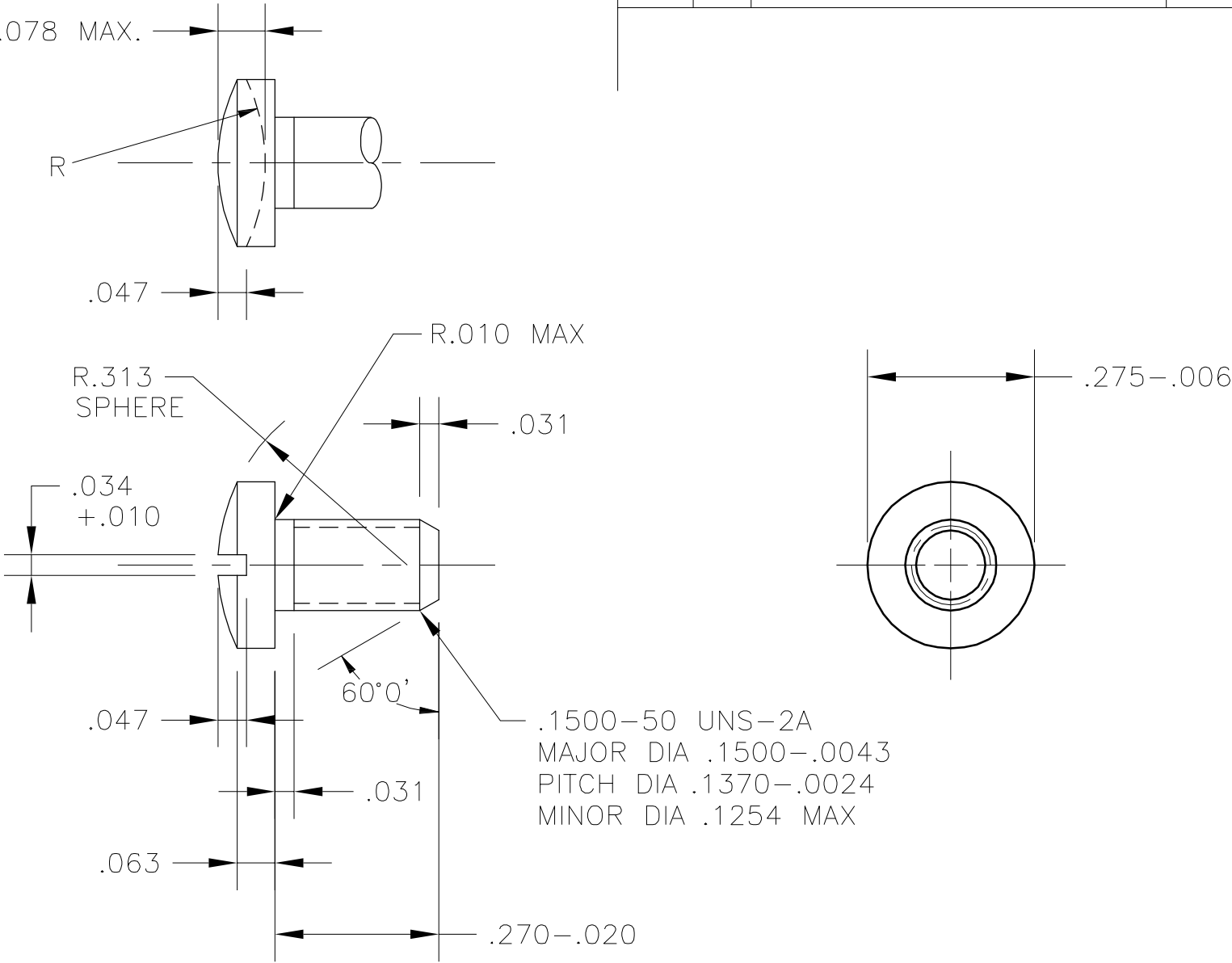
*EXCEPT FOR CRIMPED END

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64 DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	SPRING, RECOIL, INNER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
		SIZE B	FSCM NO.	DWG NO.	REV
	DO NOT SCALE DRAWING	DATE: 15 AUGUST 2025	SCALE 4:1	SHEET 1 OF 1	



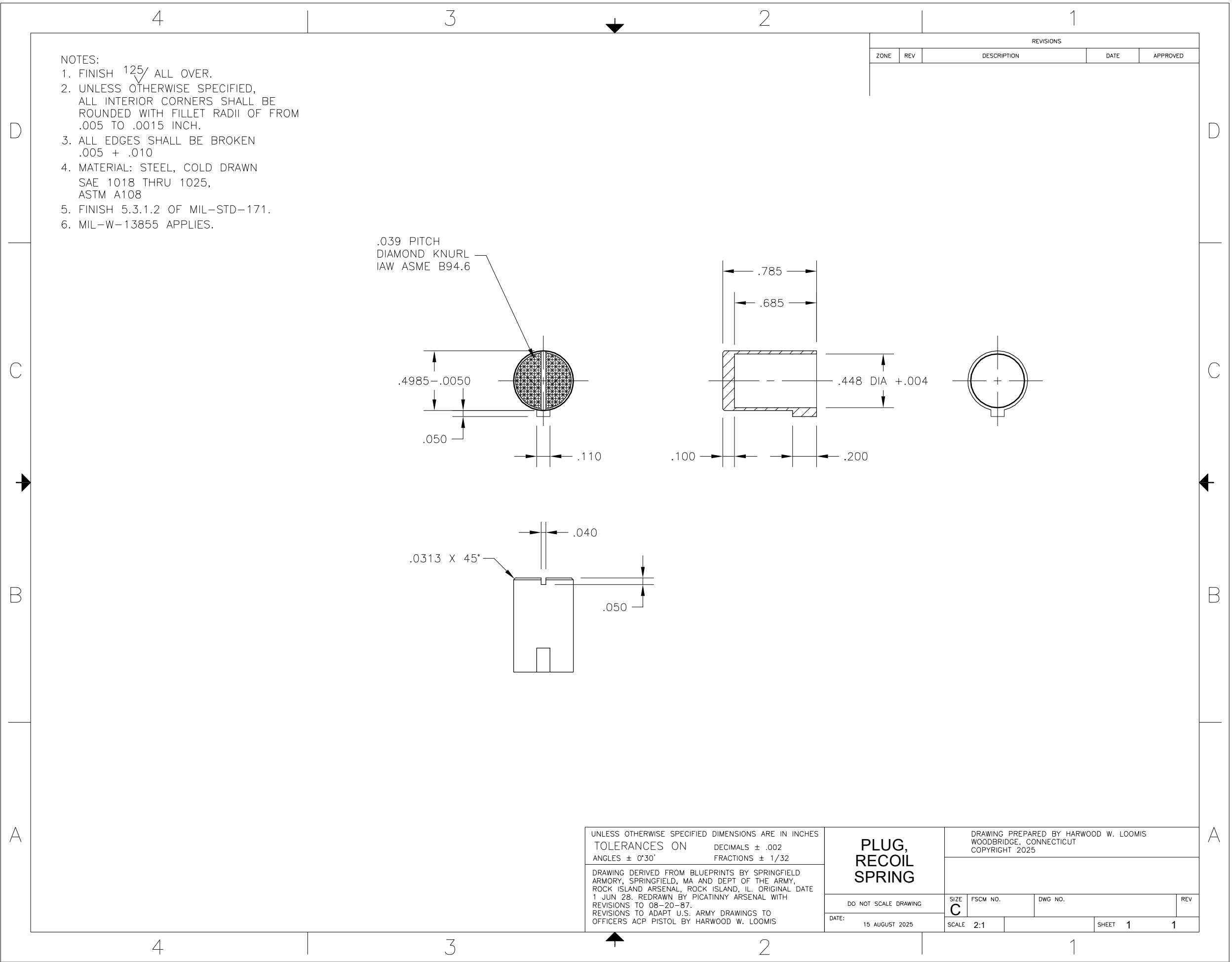
NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE AT 1600° F ± 25° TO A CASE DEPTH .002 TO .005. OIL QUENCH. TEMPER AT 450° F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
- 3. STEEL, CARBON: SAE 1018, 1020, 1117, ASTM A108.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.1.2 OF MIL-STD-171.



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32 DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. REVISED AND REDRAWN BY PICATINNY ARSENAL, NJ, 6-21-87. REDRAWN TO RECORD U.S. ARMY DRAWINGS FOR OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	SCREW, STOCK	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025		
	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.
DATE: 15 AUGUST 2025	SCALE 4:1			REV
		SHEET 1 OF 1		



- NOTES:
1. FINISH $125\sqrt{\text{ }}$ ALL OVER.
 2. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .0015 INCH.
 3. ALL EDGES SHALL BE BROKEN .005 + .010
 4. MATERIAL: STEEL, COLD DRAWN SAE 1018 THRU 1025, ASTM A108
 5. FINISH 5.3.1.2 OF MIL-STD-171.
 6. MIL-W-13855 APPLIES.

.039 PITCH
DIAMOND KNURL
IAW ASME B94.6

.4985-.0050

.050

.110

.785

.685

.448 DIA +.004

.100

.200

.040

.0313 X 45°

.050

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 JUN 28. REDRAWN BY PICATINNY ARSENAL WITH REVISIONS TO 08-20-87.
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**PLUG,
RECOIL
SPRING**

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
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DO NOT SCALE DRAWING

DATE: 15 AUGUST 2025

SIZE

C

FSCM NO.

DWG NO.

REV

SCALE 2:1

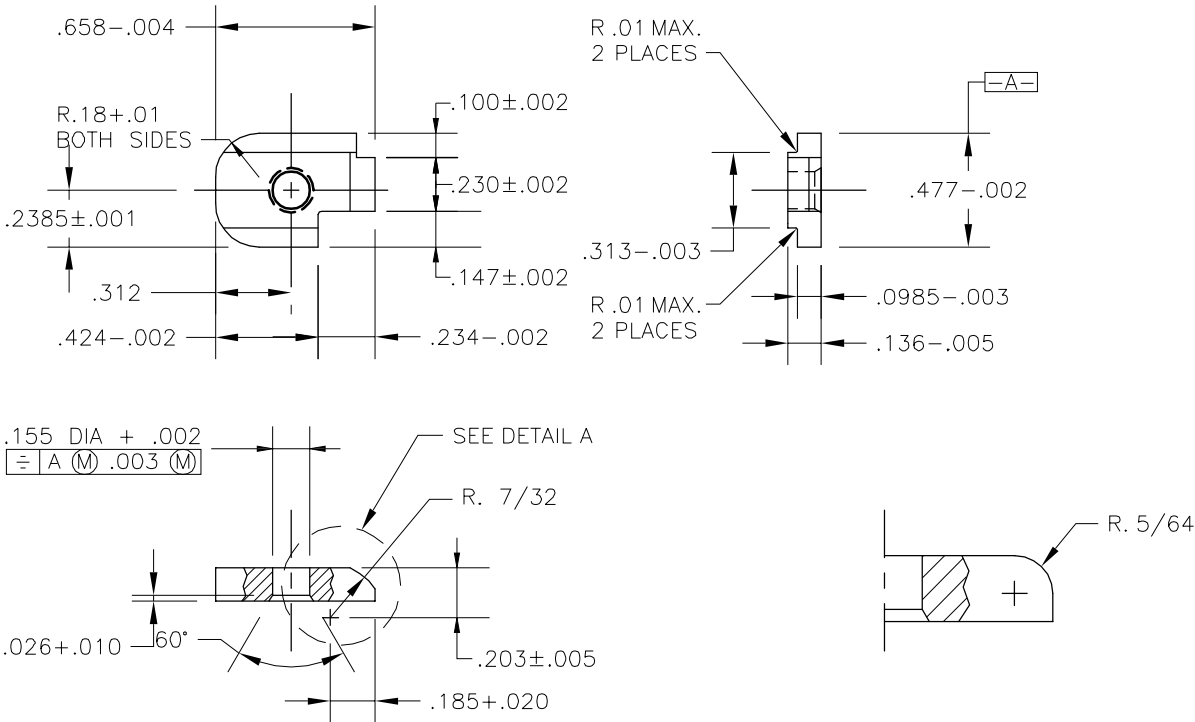
SHEET 1

1

NOTES:

1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED
2. MATERIAL: STEEL, SAE 1060 OR 1095 - ASTM A108,
OR STEEL, SAE 4140 OR 4150 - ASTM A304
3. CLASSIFICATION AND INSPECTION OF
INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH
CLASS I, GRADE 8, MIL-C-6021.
4. HEAT AT 1520° TO 1560° F. OIL QUENCH. TEMPER AT
APPROXIMATELY 750° F FOR ONE HOUR TO HARDNESS
SPECIFIED. HEAT TREATMENT METHOD IS FOR
GUIDANCE, EXCEPT THAT TIME AT TEMPERATURE
SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.
7. ALL EDGES SHALL BE BROKEN .005+.010
UNLESS OTHERWISE SPECIFIED.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



DETAIL A
SCALE 4:1
ORIGINAL SMALL RADIUS
DESIGN PRIOR TO 1/1/1918

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/32

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD
ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY,
ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE
1 MAY 28. SPRINGFIELD ARSENAL REVISIONS TO 2-10-75.
ROCK ISLAND ARSENAL REVISIONS TO 10-31-91.
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO
OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**STOP,
FIRING PIN,
SERIES 80**

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
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DATE: 15 AUGUST 2025	SCALE 2:1		SHEET 1 OF 1	

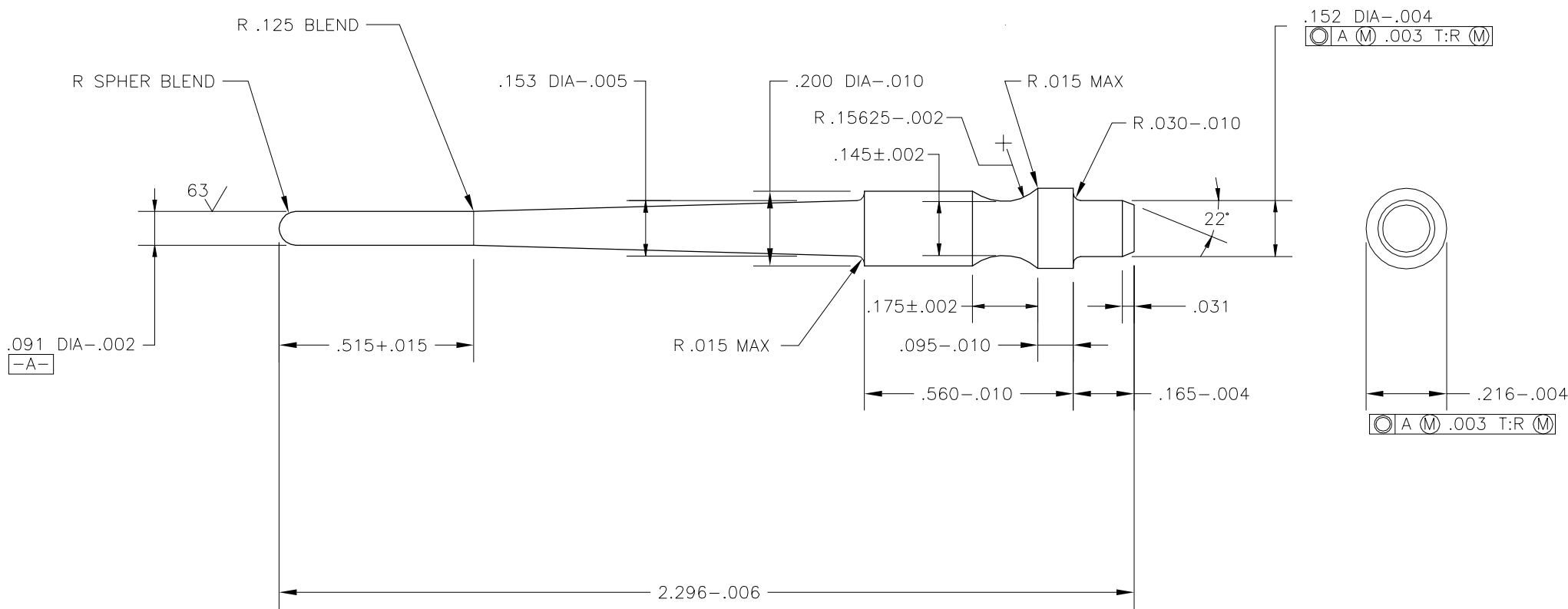
NOTES:

1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED
2. MATERIAL: STEEL, SAE 1060, 1070 OR 1095 – ASTM A108 OR ASTM A576. AUSTENITIC GRAIN SIZE 7 OR FINER.
3. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. TAKE HARDNESS READING ON .20 D:A-.01.
5. FINISH 5.3.1.2 OR 5,3,2,2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

D
C
B
A

D
C
B
A



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/32

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. SPRINGFIELD ARSENAL REVISIONS TO 2-10-75. ROCK ISLAND ARSENAL REVISIONS TO 6-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

PIN,
FIRING,
SERIES 80

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

DO NOT SCALE DRAWING	SIZE C	FSCM NO.	DWG NO.	REV
DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1 OF 1	

NOTES:

- 1. STRESS RELIEVE AT 435° ± 10° F
FOR 20 MINUTES AFTER FORMING
- 2. MANUFACTURE IN ACCORDANCE WITH
MIL-S-13572 TYPE 1, GRADE A, EXCEPT
DO NOT COMPRESS TO SOLID HEIGHT
- 3. MATERIAL:
MUSIC WIRE, STEEL, SPEC QQ-W-470

INSIDE DIA. FREE, NOT LESS THAN_____091
DIAMETER OF WIRE (APPROX)_____026
OUTSIDE DIA. SOLID, NOT MORE THAN_____149
FREE LENGTH (APPROX)_____708
ACTIVE COILS_____11 REF
TOTAL COILS_____13 REF
DIRECTION OF HELIX_____RH
LOAD AT COMPRESSED LENGTH OF .550 (BASIC) = 5.7 LB ± 0.5 LB
LOAD AT COMPRESSED LENGTH OF .456 (BASIC) = 8.5 LB ± .07 LB

SOLID LENGTH_____364 MAX
TYPE OF ENDS_____PLAIN (OPEN ENDS NOT GROUND)
REDUCE ID OF LAST COIL ON BOTH ENDS TO .085 DIA-.010

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY _ _ .152 MIN.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	SPRING, MAGAZINE CATCH	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBRIDGE, CONNECTICUT			
		COPYRIGHT 2025			
	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.
	DATE: 15 AUGUST 2025		SCALE	SHEET 1 OF 1	

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD
ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY,
ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY
PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.

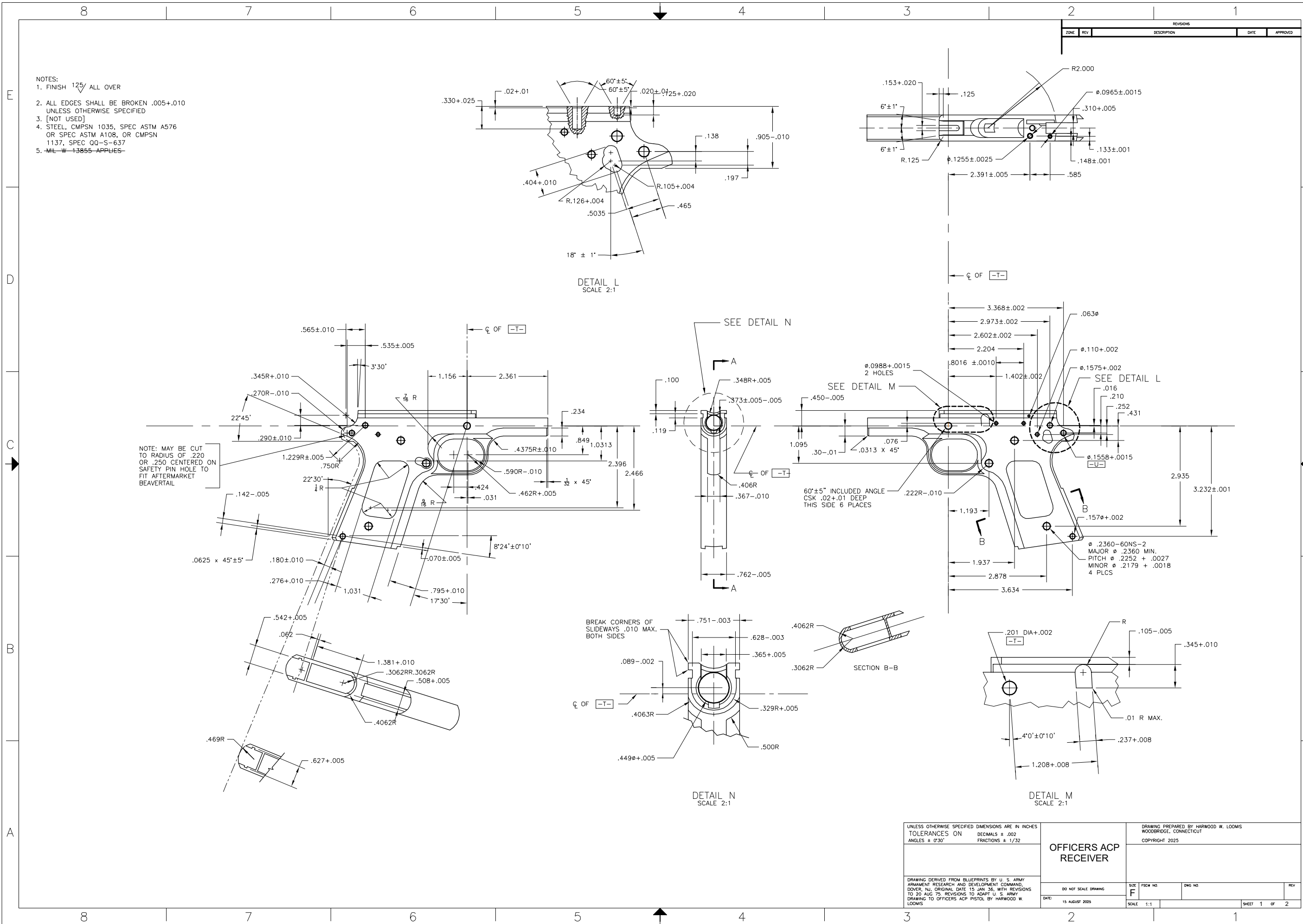
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO
OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

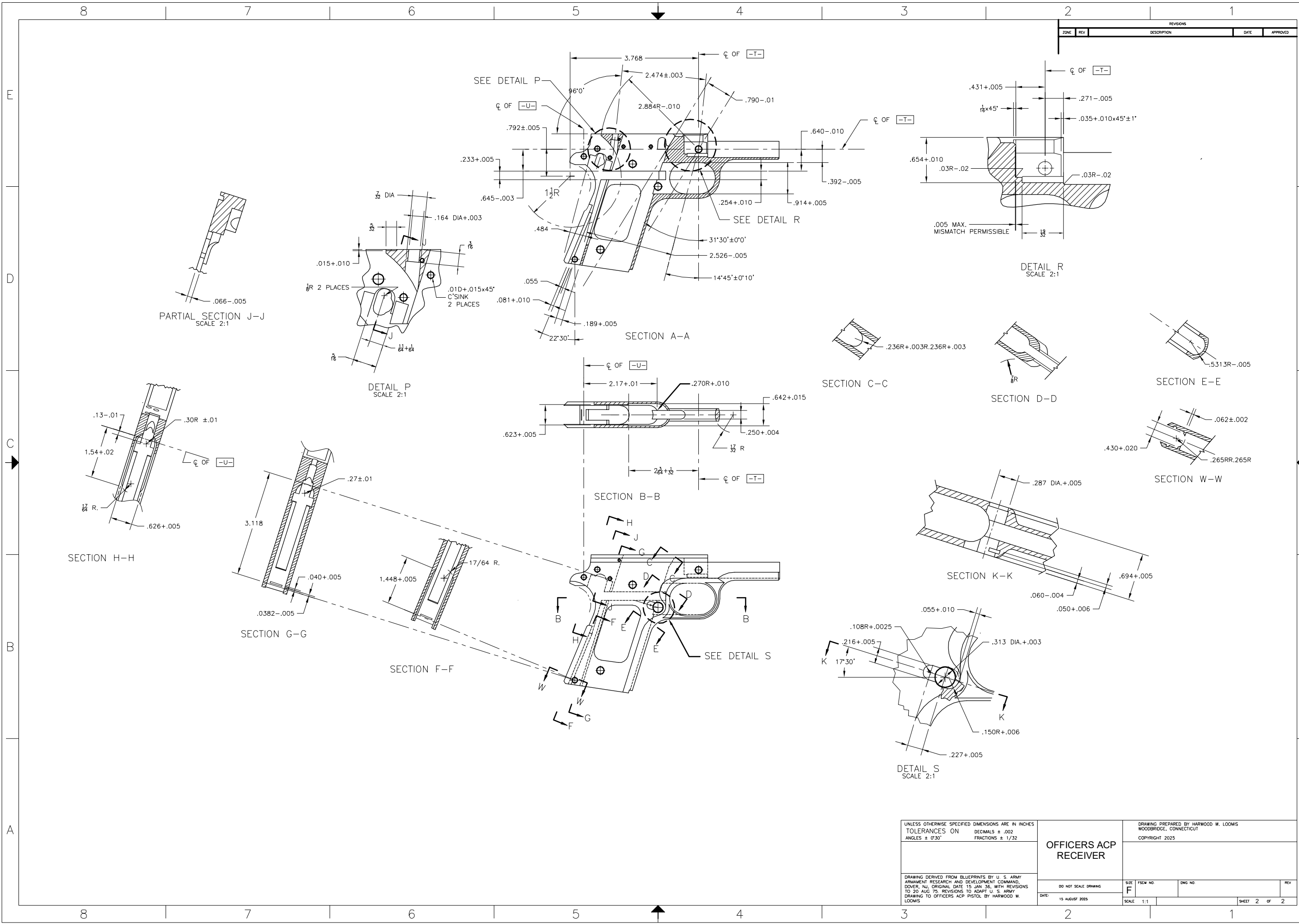
MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,
TYPE I, GRADE A

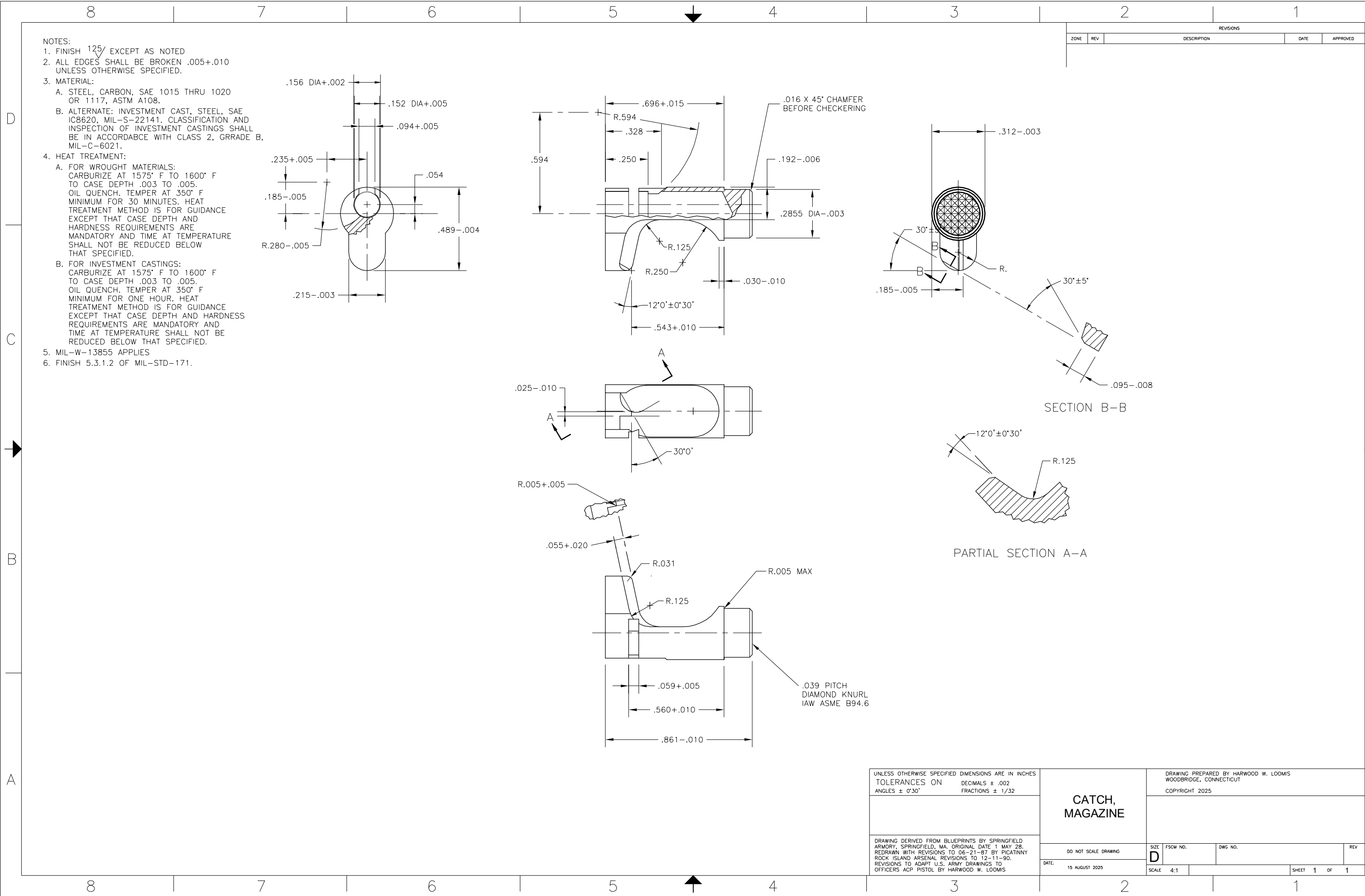
WIRE DIAMETER ----- .026
COIL DIAMETER (OO) ----- .207+.005
FREE LENGTH ----- 1.70 REF
ACTIVE COILS ----- 38
TOTAL COILS ----- 40
DIRECTION OF HELIX ----- OPTIONAL
LOAD AT COMPRESSED LENGTH OF 1.36 ---- 1.030 LB±0.135 LB *EXCEPT FOR CRIMPED END
LOAD AT COMPRESSED LENGTH OF ----
SPRING RATE ----- 3.00 LB/IN
SOLID LENGTH ----- 1.066 MAX
TYPE OF ENDS ----- SQUARED AND GROUND

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY ---- .219 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY-- .150 MAX*
CRIMP ONE END COIL TO .135+.010 I.D.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64 DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	SPRING, FIRING PIN	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025				
		DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
		DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1 OF 1	

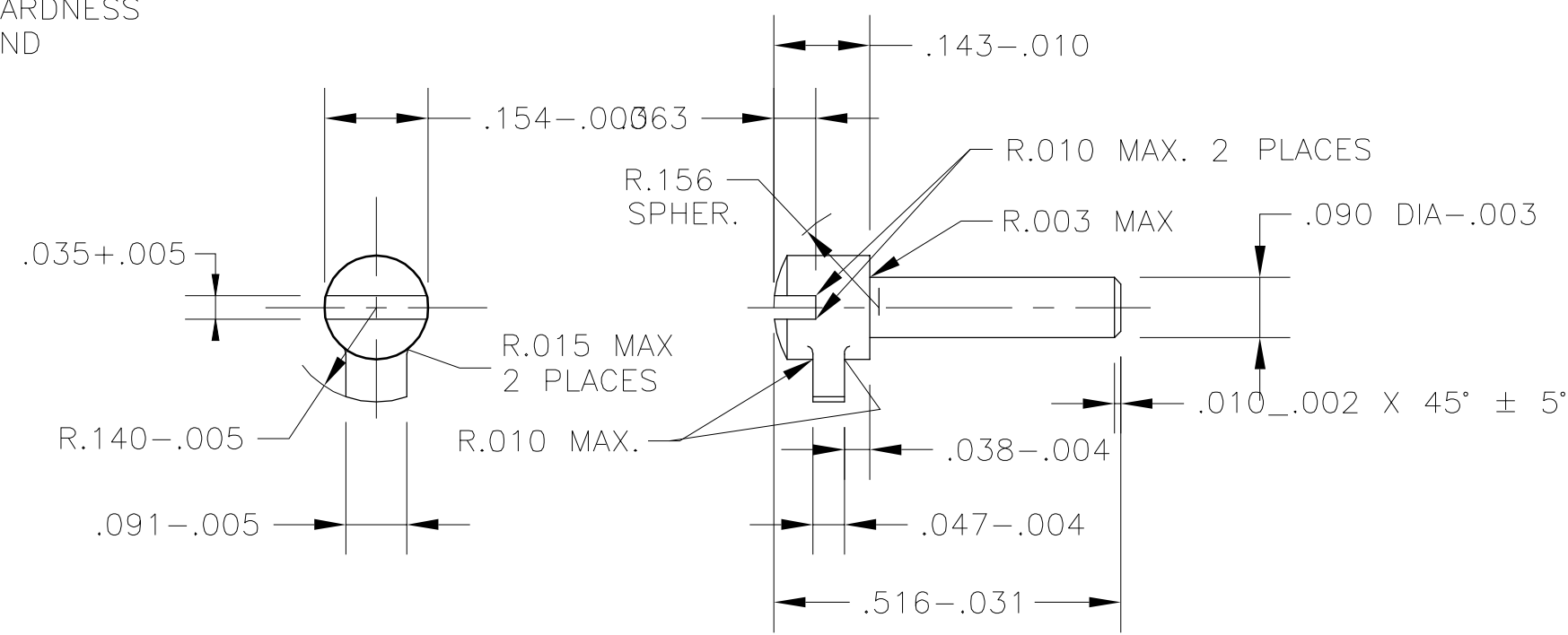






NOTES:

- 1. FINISH 125/ EXCEPT AS NOTED.
- 2. MATERIAL: STEEL, CARBON: SAE 1018 THRU 1020, 1117: ASTM A108
- 3. CARBURIZE AT 1575° F TO 1600° F TO CASE DEPTH OF .003 TO .005. OIL QUENCH. TEMPER 450° FOR 20 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 4. REMOVE ALL BURRS AND SHARP EDGES. R .005 MAX.
- 5. MIL-W-13855 APPLIES.
- 6. FINISH 5.3.1.2 OF MIL-STD-171.

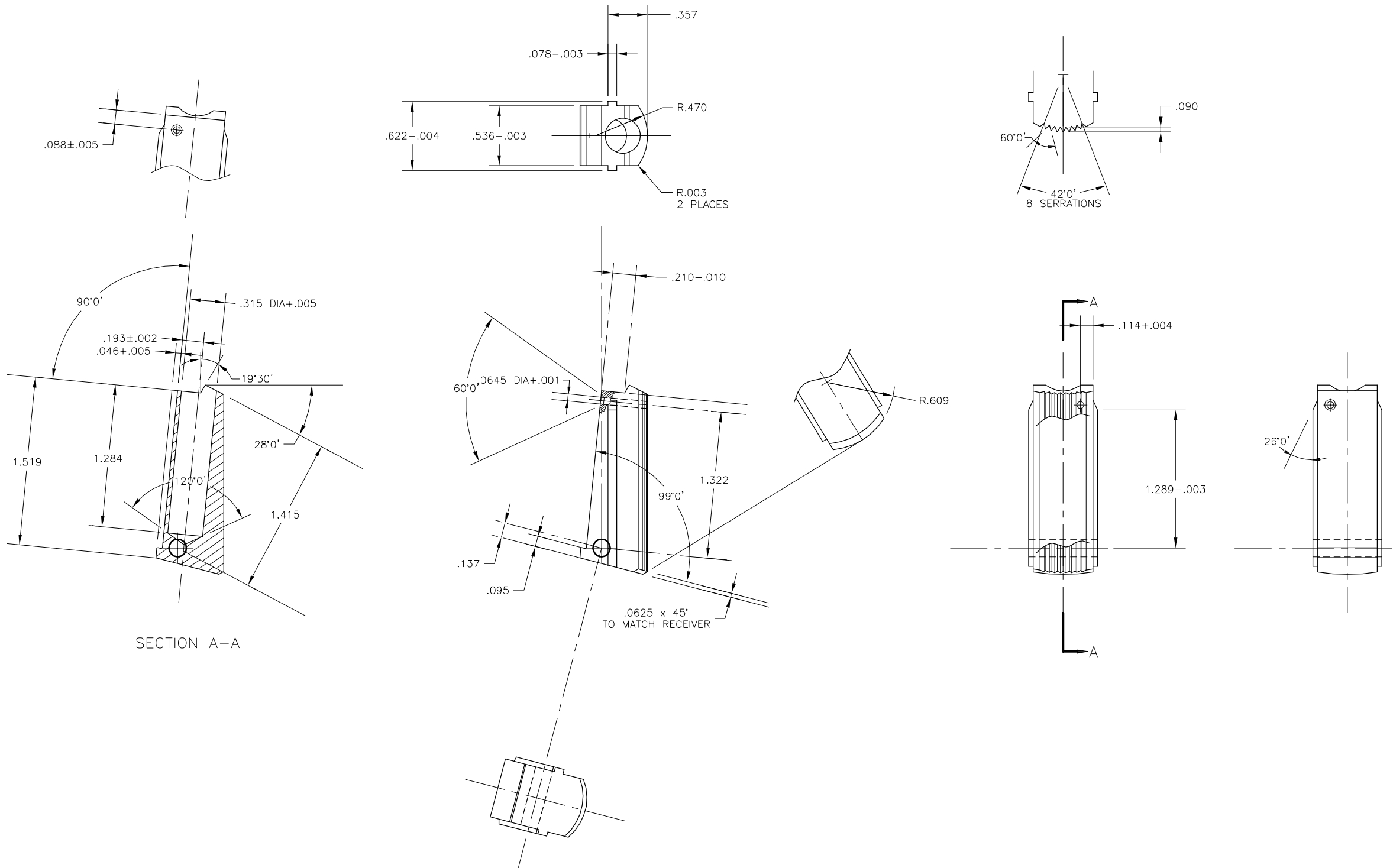


REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32 DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	LOCK, MAGAZINE CATCH	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.
DATE: 15 AUGUST 2025		SCALE 4:1			REV
			SHEET 1 OF 1		

- NOTES:
1. FINISH 125/ ALL OVER.
2. MATERIAL: STEEL, CARBON: SAE 1015 THRU 1025; 1117 THRU 1137;
ASTM 108 OR STEEL, SAE 1015 THRU 1025; ASTM A576
3. MIL-W-13855 APPLIES

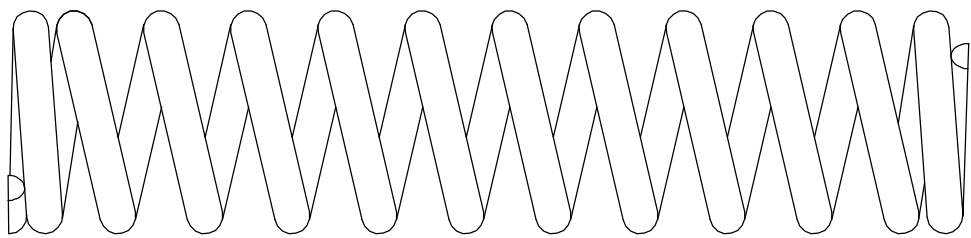
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/32		DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWINGS CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS		HOUSING, MAINSRING			
DO NOT SCALE DRAWING		SIZE D	FSCM NO.	DWG NO.	REV
DATE: 15 AUGUST 2025		SCALE 2:1	SHEET 1 OF 1		



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



WIRE DIAMETER ----- .0475
COIL DIAMETER (OO) ----- .297+.003
FREE LENGTH ----- 1.315
ACTIVE COILS ----- 10.5
TOTAL COILS ----- 12.5
DIRECTION OF HELIX ----- RH
LOAD AT COMPRESSED LENGTH OF ----- .802" = 23.0 LBS±2.0 LBS
LOAD AT COMPRESSED LENGTH OF ----- XX
SPRING RATE ----- 44.86 LBS/IN.
SOLID LENGTH ----- .594
TYPE OF ENDS ----- CLOSED & GROUND

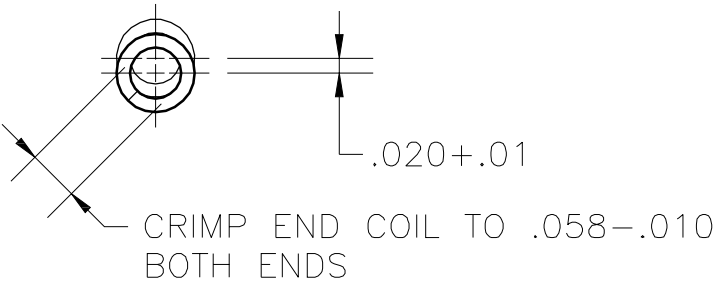
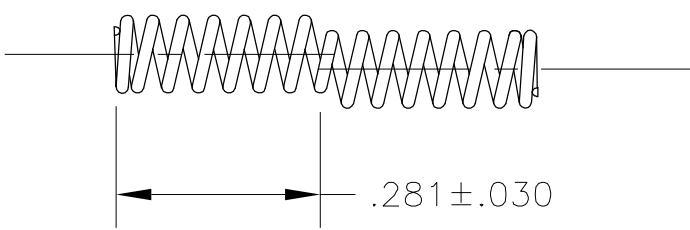


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	MAIN (HAMMER) SPRING	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1 OF 1	



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REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



→

WIRE DIAMETER ----- .018
COIL DIAMETER (OO) ----- .104±.003
FREE LENGTH ----- .593 REF
ACTIVE COILS ----- 12.5
TOTAL COILS ----- 14.5
DIRECTION OF HELIX ----- LH
LOAD AT COMPRESSED LENGTH OF ----- .400" = 2.500 LBS±0.500 LBS
LOAD AT COMPRESSED LENGTH OF ----- XX
SPRING RATE ----- .160 LBS/IN. REF
SOLID LENGTH ----- .279 MAX.
TYPE OF ENDS ----- SQUARED & GROUND

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY ---- .109 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY ---- MIN

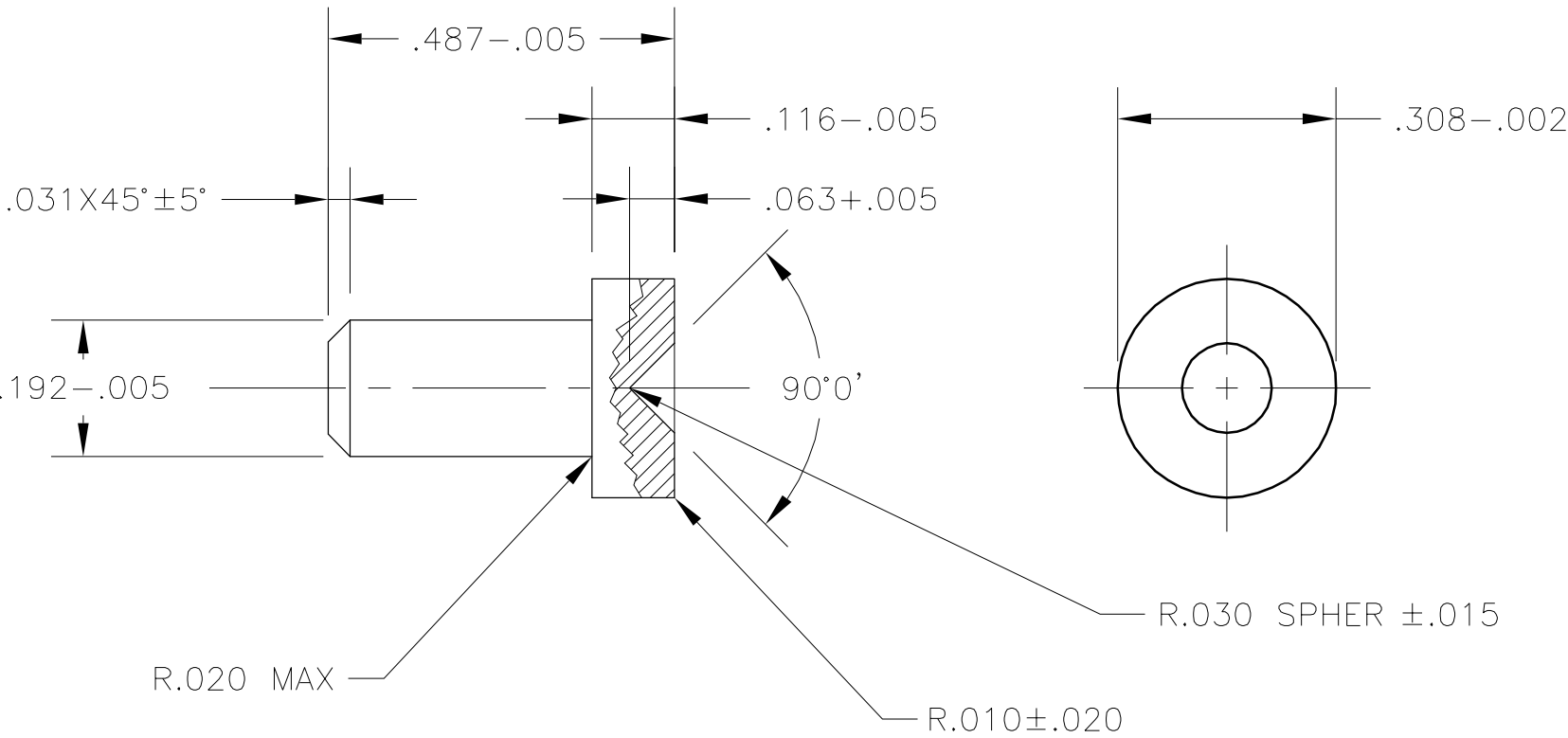
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	SPRING, PLUNGER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBRIDGE, CONNECTICUT			
		COPYRIGHT 2025			
	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. SPRINGFIELD ARMORY REVISIONS TO 2-10-75. ROCK ISLAND ARSENAL REVISIONS TO 10-21-93. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1 OF 1	

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NOTES:

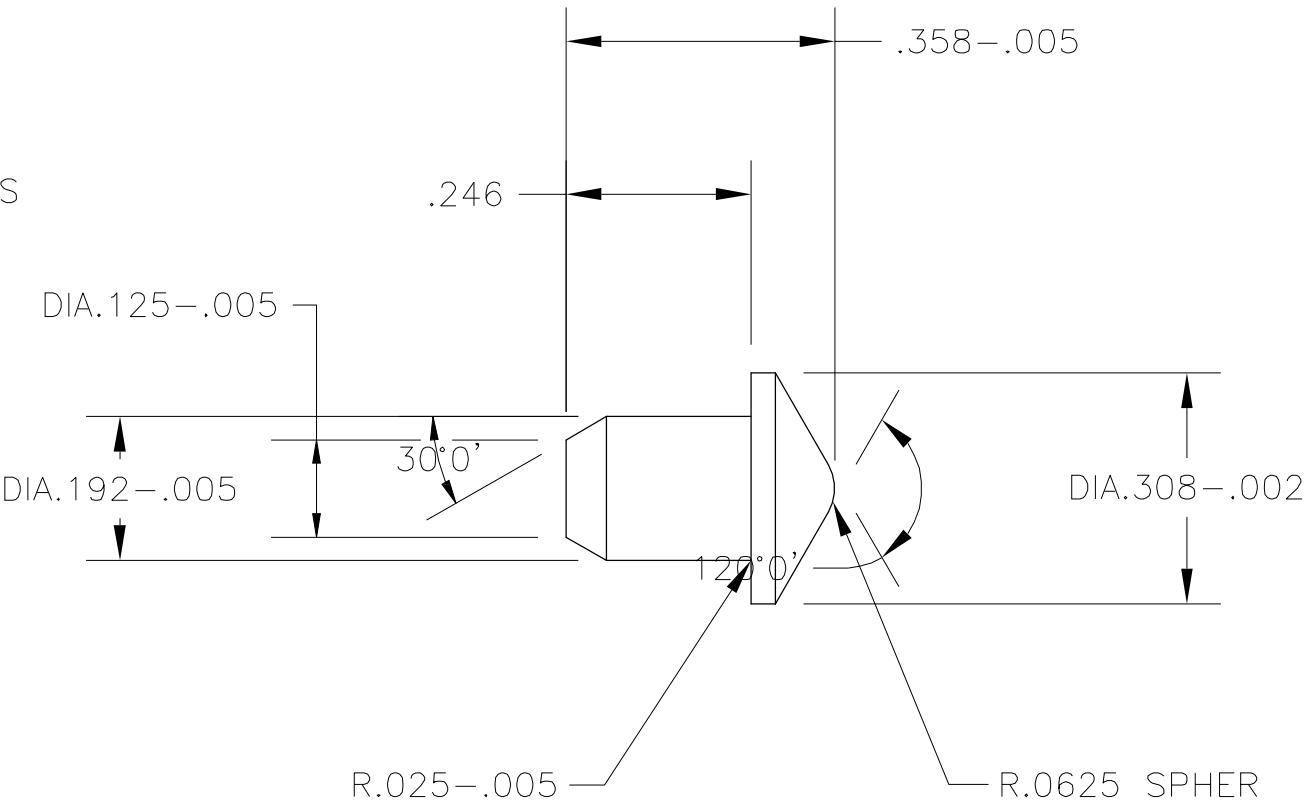
- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE AT 1600° F ± 25° TO A CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350° F MIN FOR 30 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MATERIAL: STEEL, CARBON, SAE 1018 THRU 1020, 1117: ASTM A108 OR ASTM A576.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.2.2 OF MIL-STD-171.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	CAP, MAINSRING	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.
	DATE: 15 AUGUST 2025		SCALE 4:1	SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE AT 1600° F ± 25° TO A CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350° F MIN FOR 30 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MATERIAL: STEEL, CARBON, SAE 1018 THRU 1020, 1117: ASTM A108 OR ASTM A576.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.2.2 OF MIL-STD-171.



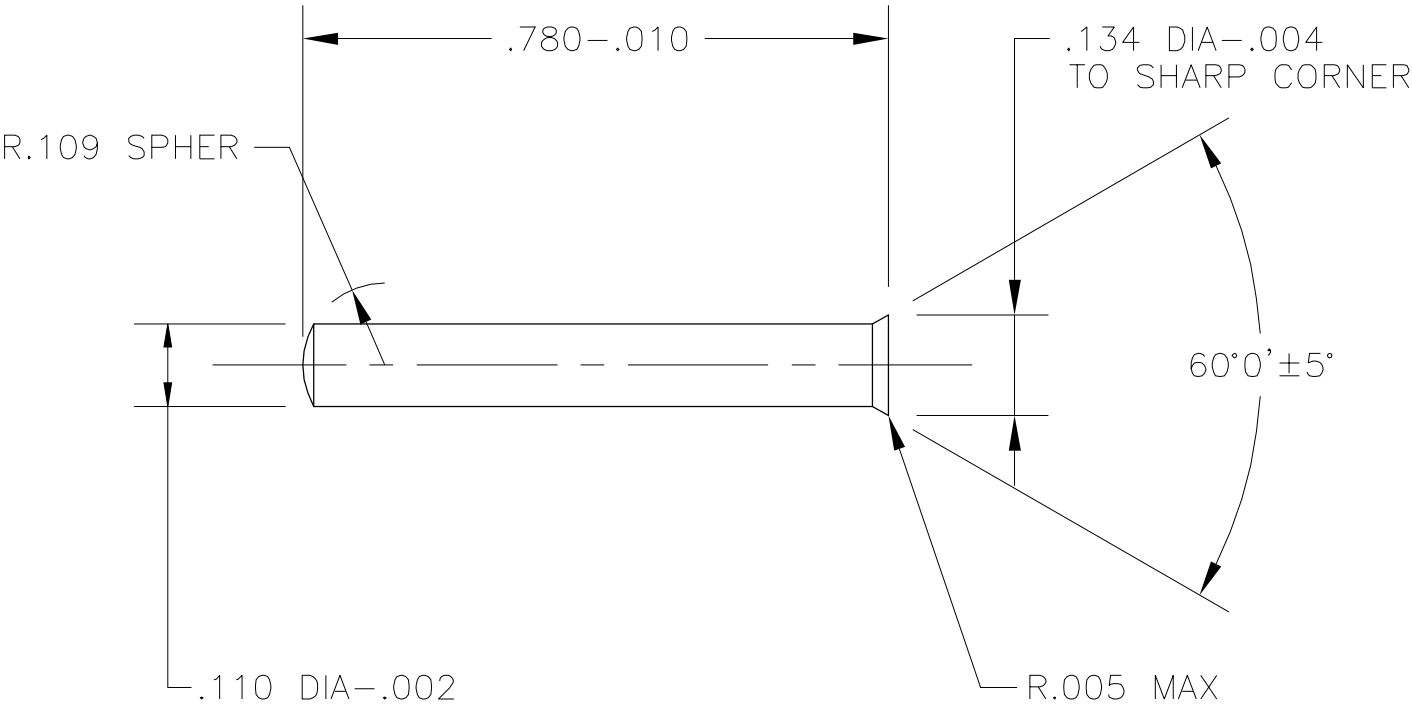
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ± 0°30'	DECIMALS ± .002 FRACTIONS ± 1/32	RETAINER, MAINSRING HOUSING PIN	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT			
			COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025		SCALE 4:1			SHEET 1 OF 1

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.2.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

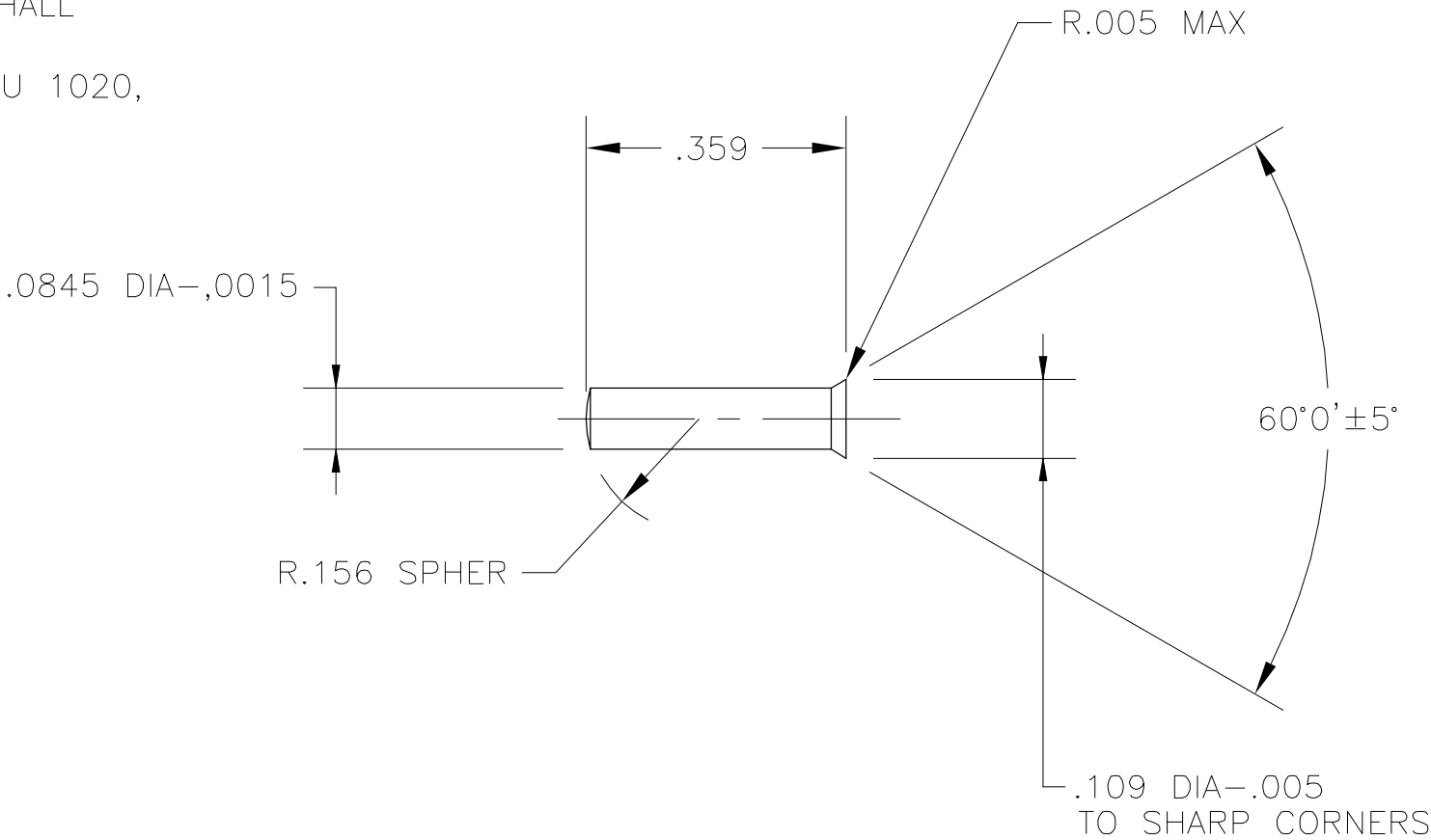


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ± 0°30'	DECIMALS ± .002 FRACTIONS ± 1/64	PIN, SEAR	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT				
			COPYRIGHT 2025				
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.							
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS		DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV	
DATE: 15 AUGUST 2025		SCALE 4:1			SHEET 1 OF 1		

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350° F MINIMUM TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MATERIAL: STEEL, CARBON, SAE 1018 THRU 1020, 1117. ASTM A108 OR ASTM A576.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.2.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

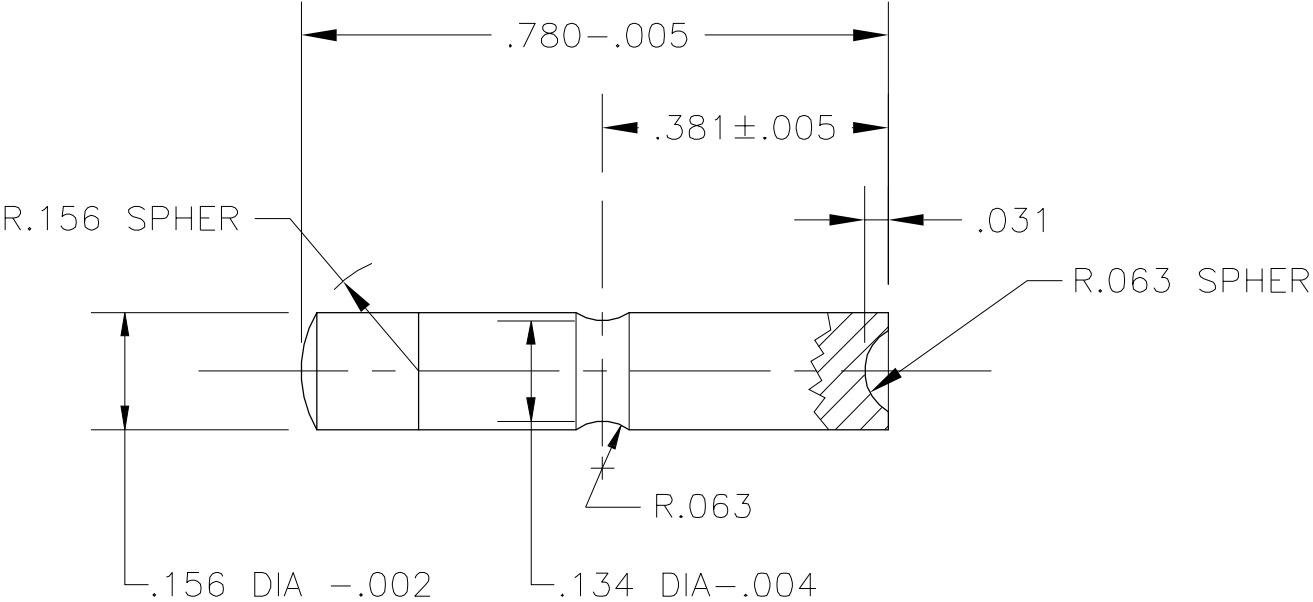


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/64	PIN, MAINSRING CAP	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025				
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 06-01-28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.		REV
	DATE: 15 AUGUST 2025	SCALE 4:1			SHEET 1 OF 1	

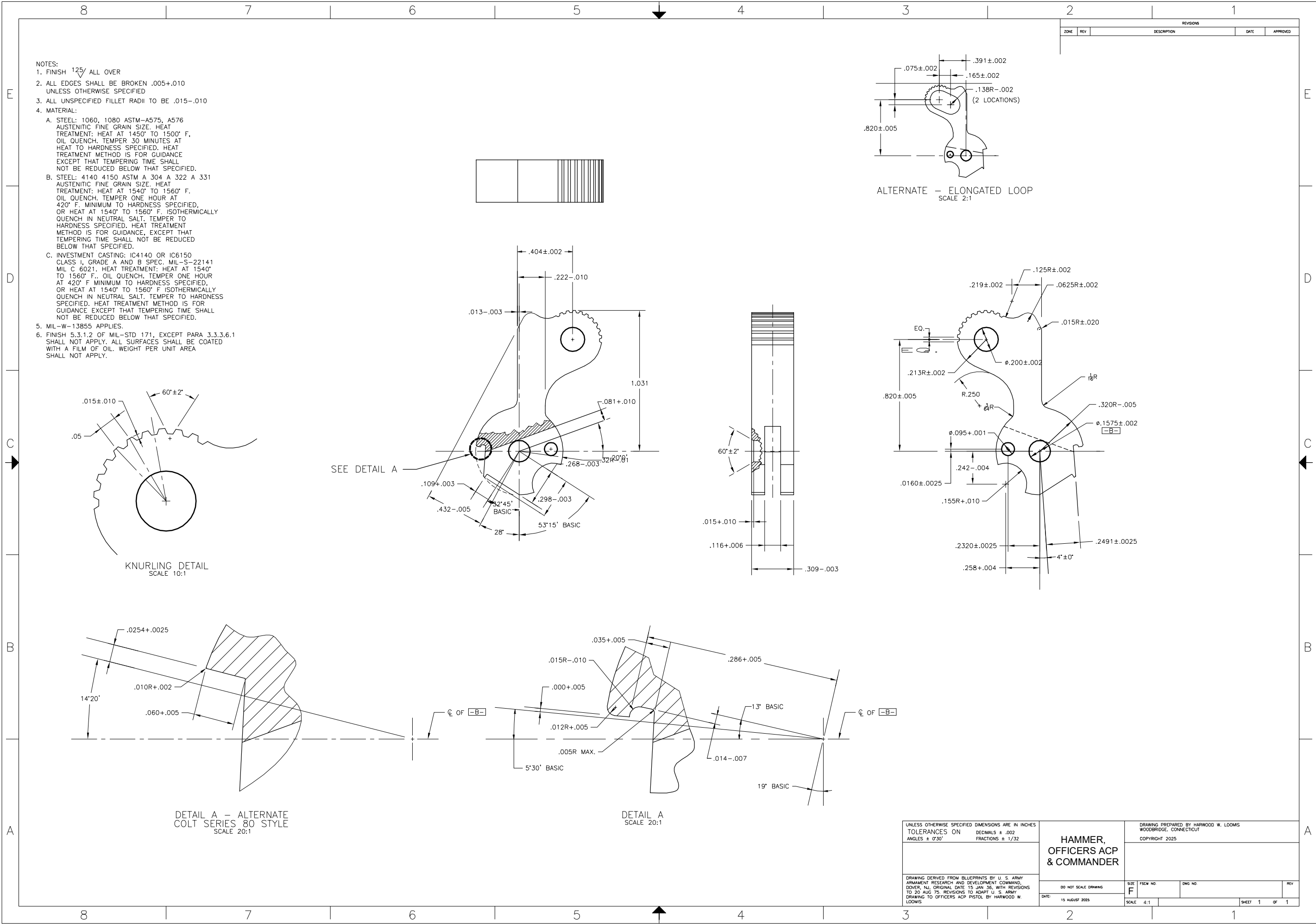
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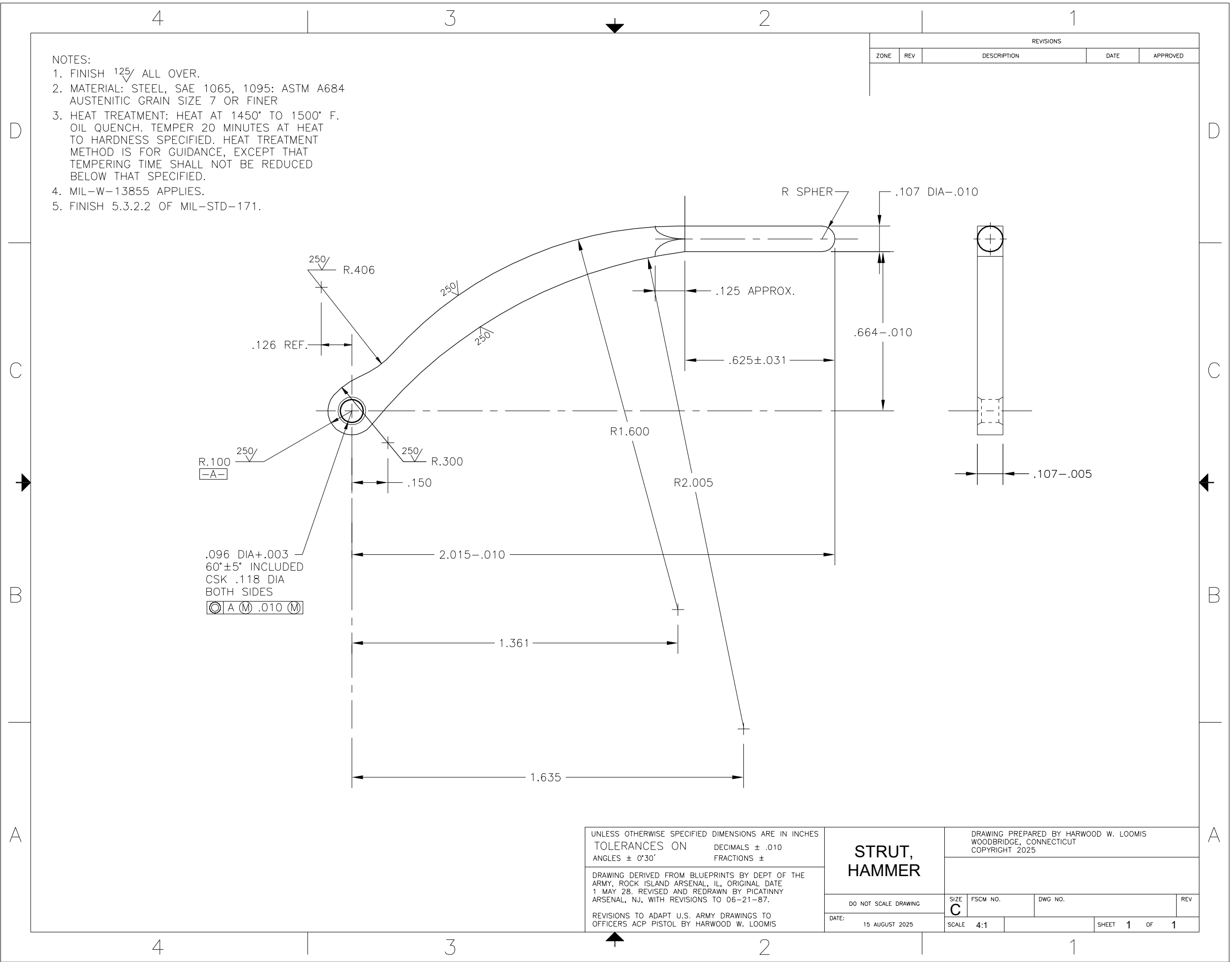
- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.2.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64	PIN, MAINSRING HOUSING	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1	OF 1

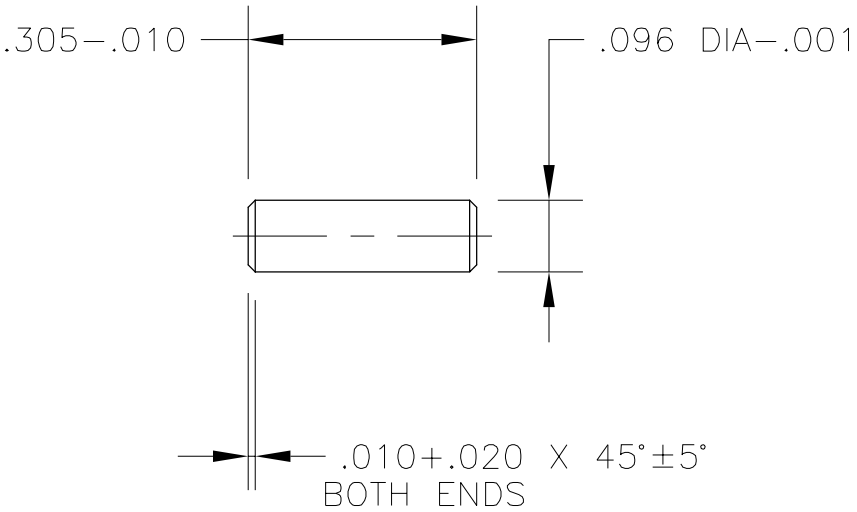




NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.2.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

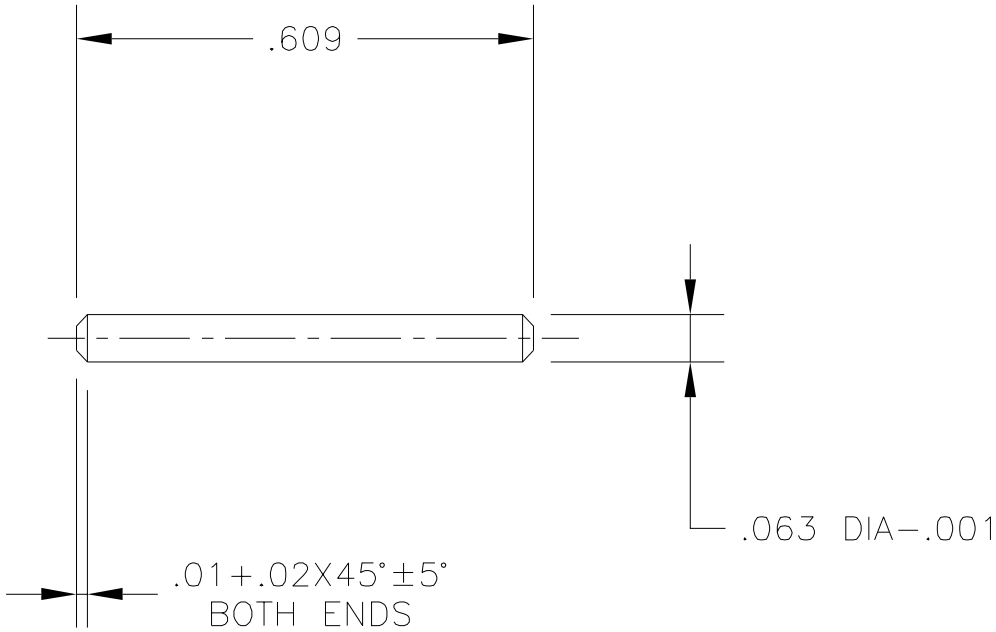


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/64	PIN, HAMMER STRUT	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025				
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.		DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DATE: 15 AUGUST 2025	SCALE 4:1			SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.1.2 OF MIL-STD-171.

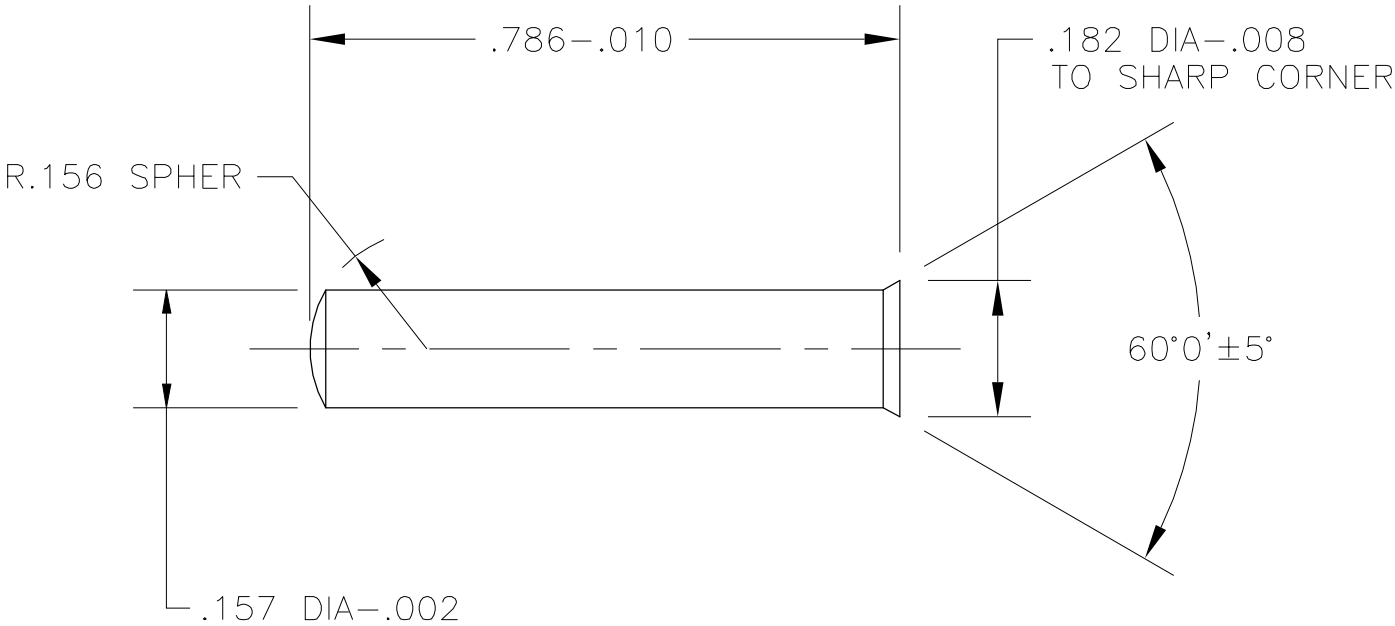
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ± 0°30'	DECIMALS ± .002 FRACTIONS ± 1/64	PIN, EJECTOR	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT			
			COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.						
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS		DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
		DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1	OF 1

NOTES:

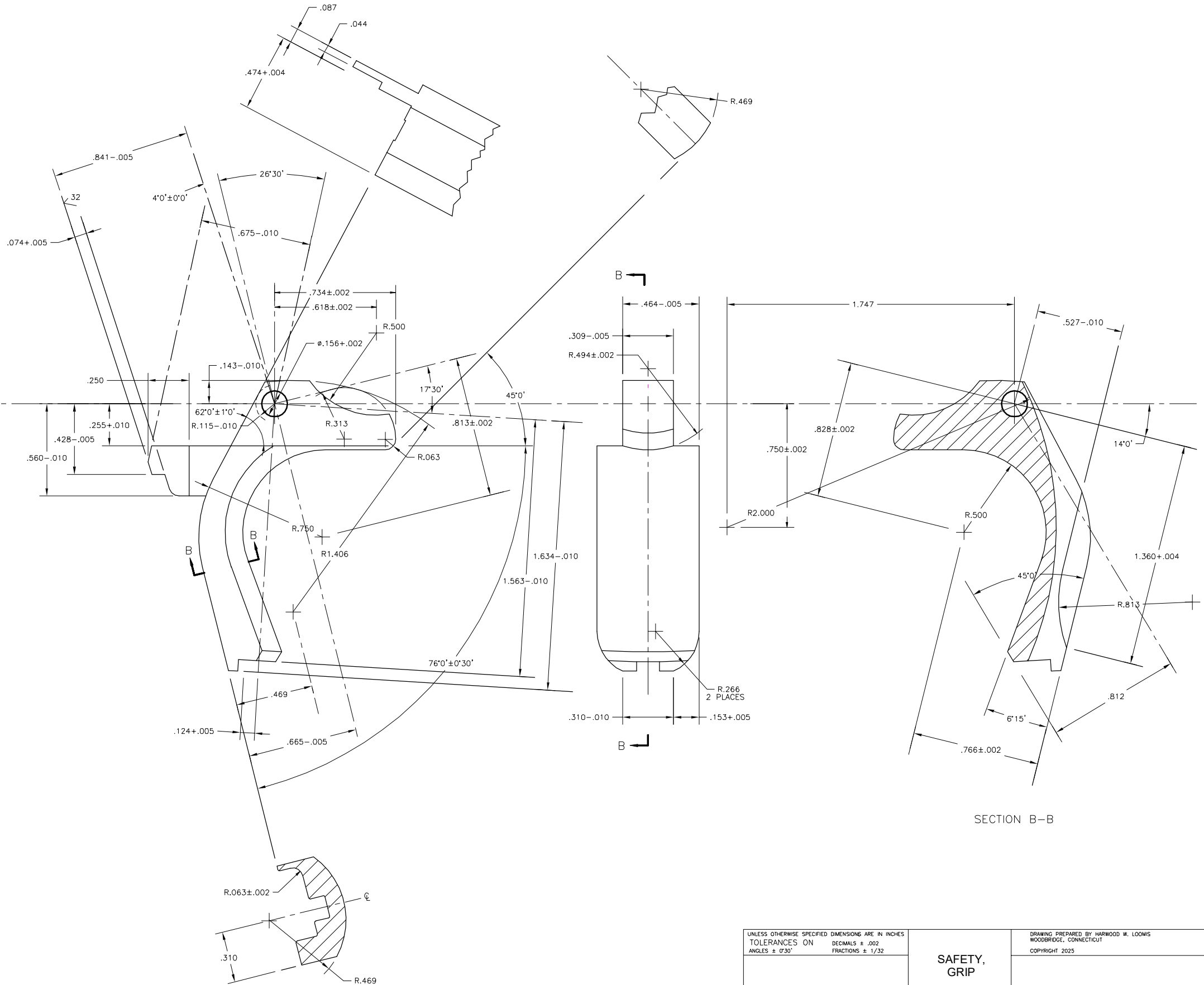
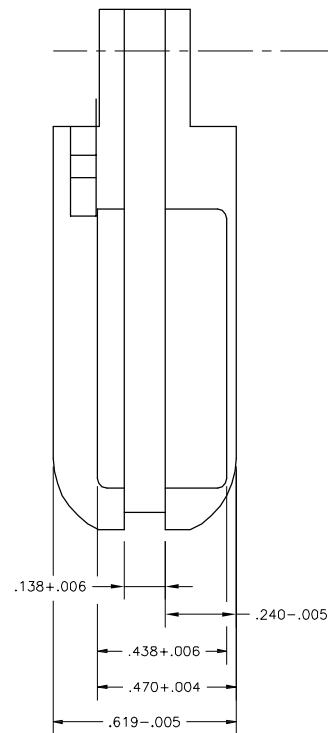
- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MIL-W-13855 APPLIES.
- 4. FINISH 5.3.2.2 OF MIL-STD-171.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ± 0°30'	DECIMALS ± .002 FRACTIONS ± 1/64	PIN, HAMMER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT				
			COPYRIGHT 2025				
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.							
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS		DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV	
DATE: 15 AUGUST 2025		SCALE 4:1			SHEET 1 OF 1		

NOTES:

1. FINISH $\sqrt{63}$ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. UNLESS OTHERWISE SPECIFIED ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .015 INCH.
4. HEAT TREATMENT: CARBURIZE TO .003 TO .005 CASE DEPTH. OIL QUENCH. TEMPER AT 350° F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE. APPLY OIL VV-L-800 TO BRIGHT AREAS.
6. MIL-W-13855 APPLIES.
7. MATERIAL:
 - A. STEEL, CARBON; SAE 1018 THRU 1020, 1117; ASTM A108.
 - B. INVESTMENT CASTING IC8620, SPEC MIL-S-22141; INSPECTION: CLASS 2, GRADE B AND C PER MIL-C-6021,
8. FINISH 5.3.1.2 OF MIL-STD-171.



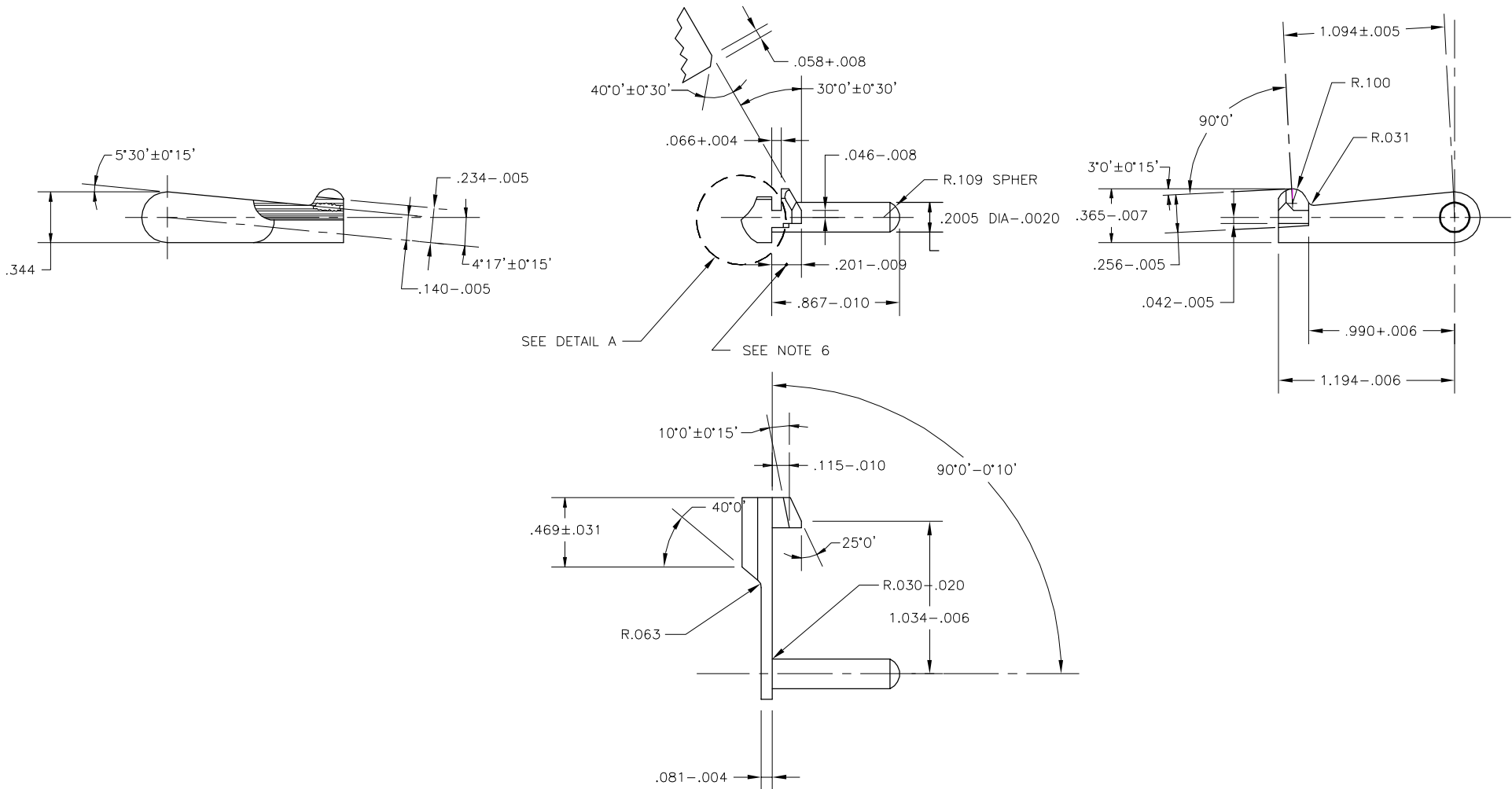
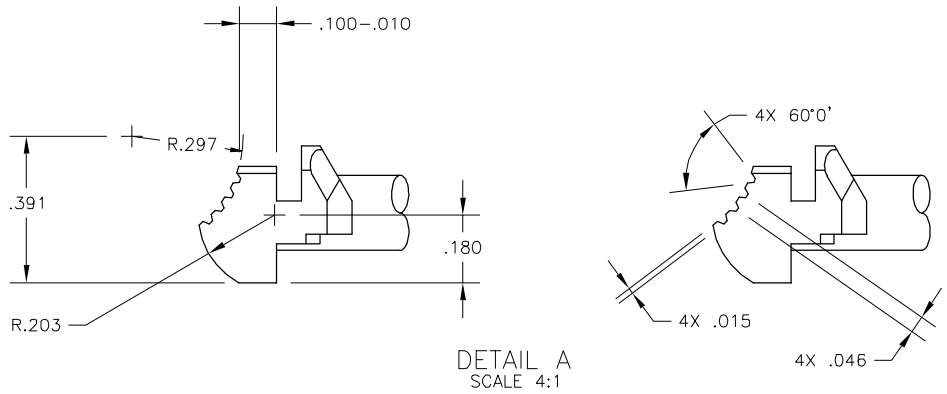
SECTION A-A

SECTION B-B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON	DECIMALS ± .002
ANGLES ± 0°30'	FRACTIONS ± 1/32
DRAWING DERIVED FROM BLUEPRINTS BY DEPARTMENT OF THE ARMY, SPRINGFIELD ARMORY, SPRINGFIELD, MASSACHUSETTS, ORIGINAL DATE 1 MAY 28, WITH REVISIONS TO 19 OCT 90. REVISIONS TO ADAPT U. S. ARMY DRAWING TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	

SAFETY GRIP		DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025	
DO NOT SCALE DRAWING	SIZE F	FSW NO.	DWG NO.
DATE: 15 AUGUST 2025	SCALE: 4:1	REV	
		SHEET 1 OF 2	

- NOTES:
1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED.
 2. ALL EDGES SHALL BE BROKEN $.005+.010$ UNLESS OTHERWISE SPECIFIED.
 3. MATERIAL:
 - A. STEEL, CARBON; SAE 1050, ASTM A576; AUSTENITIC GRAIN SIZE 6 OR FINER.
 - B. STEEL, CARBON, SAE 4140, ASTM A322 OR A331; AUSTENITIC GRAIN SIZE 6 OR FINER.
 - C. INVESTMENT CASTING IC8620, SPEC MIL-S-22141; INSPECTION: CLASS 2, GRADE B AND C PER MIL-C-6021.
 4. FINISH 5.3.1.2 OF MIL-STD-171.
 5. MIL-W-13855 APPLIES.
 6. SLIDE STOP LUG PROJECTION:
UNMARKED: $.192\text{''}-.201\text{''}$ STANDARD $.45$
NUMBER 1: $.192\text{''}-.201\text{''}$ $.45$ ACP
NUMBER 2: $.205\text{''}-.210\text{''}$ ACE, CONVERSION UNIT, $.38$ AMU & $.38$ NM
NUMBER 3: $.215\text{''}-.220\text{''}$ $.38$ ACP & $.38$ SUPER
NUMBER 4: $.40$ S&W & 10MM
M: $.192\text{''}-.201\text{''}$ MATCH



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD
ARMORY, SPRINGFIELD, MA, ORIGINAL DATE 1 MAY 28.
REDRAWN BY PICATINNY ARSENAL WITH REVISIONS
04-19-90.

REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO
OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

SLIDE STOP

DO NOT SCALE DRAWING

DATE:

15 AUGUST 2025

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

SIZE

D

FSCM NO.

DWG NO.

REV

SCALE

2:1

DATE:

15 AUGUST 2025

SHEET

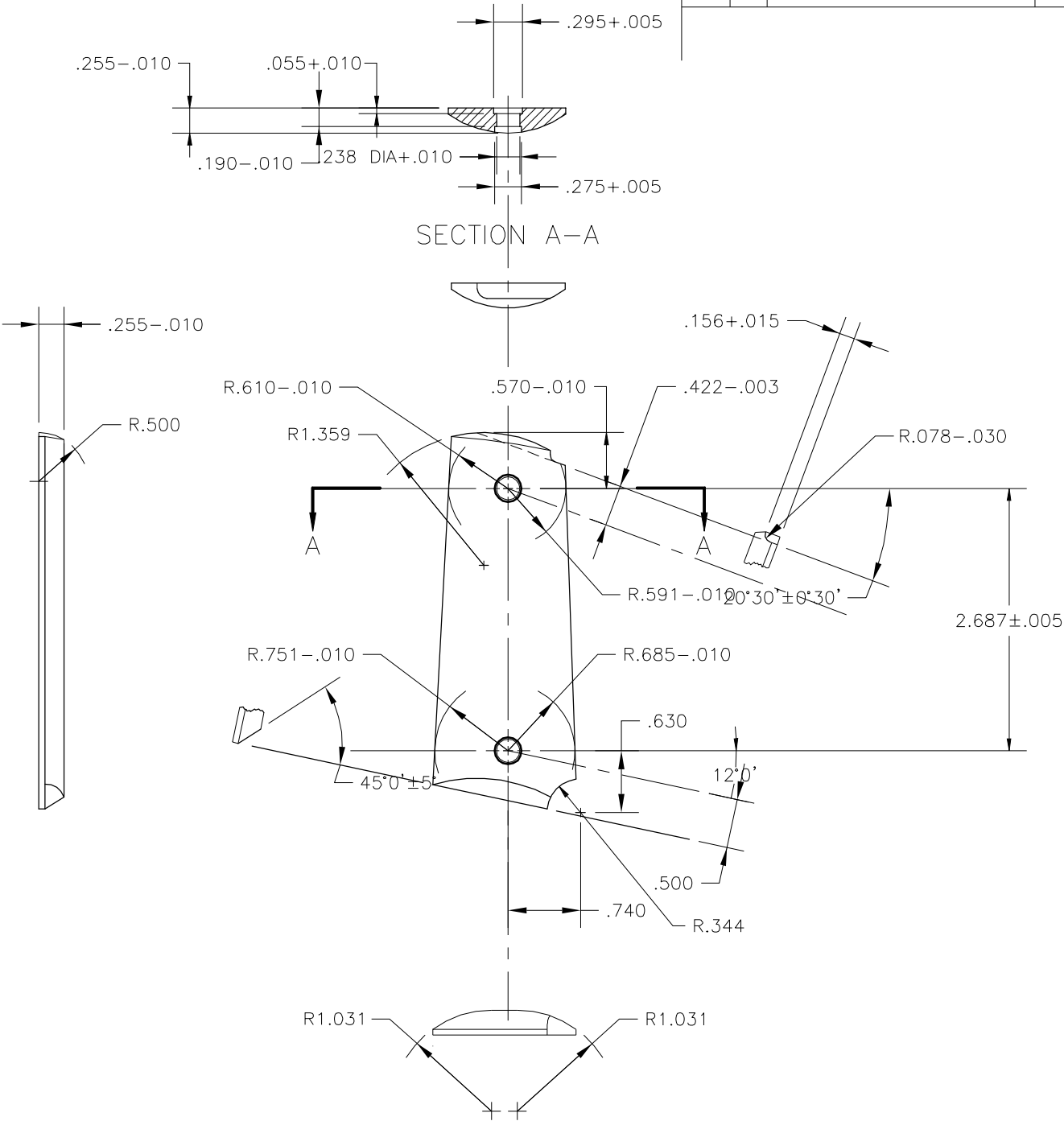
1

OF

1

NOTES:

1. AT DIFFERENT TIMES, THE COLT FACTORY HAS USED GRIPS (STOCKS) OF SMOOTH WALNUT, CHECKERED WALNUT, CHECKERED COCOBOLO, RBBER GRIPS BY PACHMAYR WITH INTEGRAL FRONT STRAP, OR BY HOGUE WITH INTEGRAL FRONT STRAP.
2. FOR CLARITY, DRAWING IS BASED ON SMOOTH SURFACE STOCKS IN ORDER TO BETTER ILLUSTRATE DIMENSIONS.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/64

DRAWING DERIVED FROM BLUEPRINTS BY ROCK ISLAND ARSENAL, ROCK ISLAND, IL, AND DEPT OF THE ARMY, ORIGINAL DATE 15 JAN 36. REDRAWN AND REVISED THROUGH 7 OCT 76.

REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**STOCK,
LEFT HAND,
WALNUT**

DO NOT SCALE DRAWING

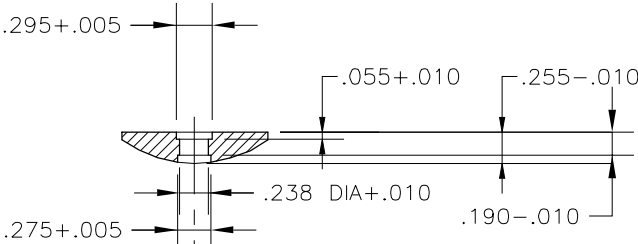
DATE: 15 AUGUST 2025

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

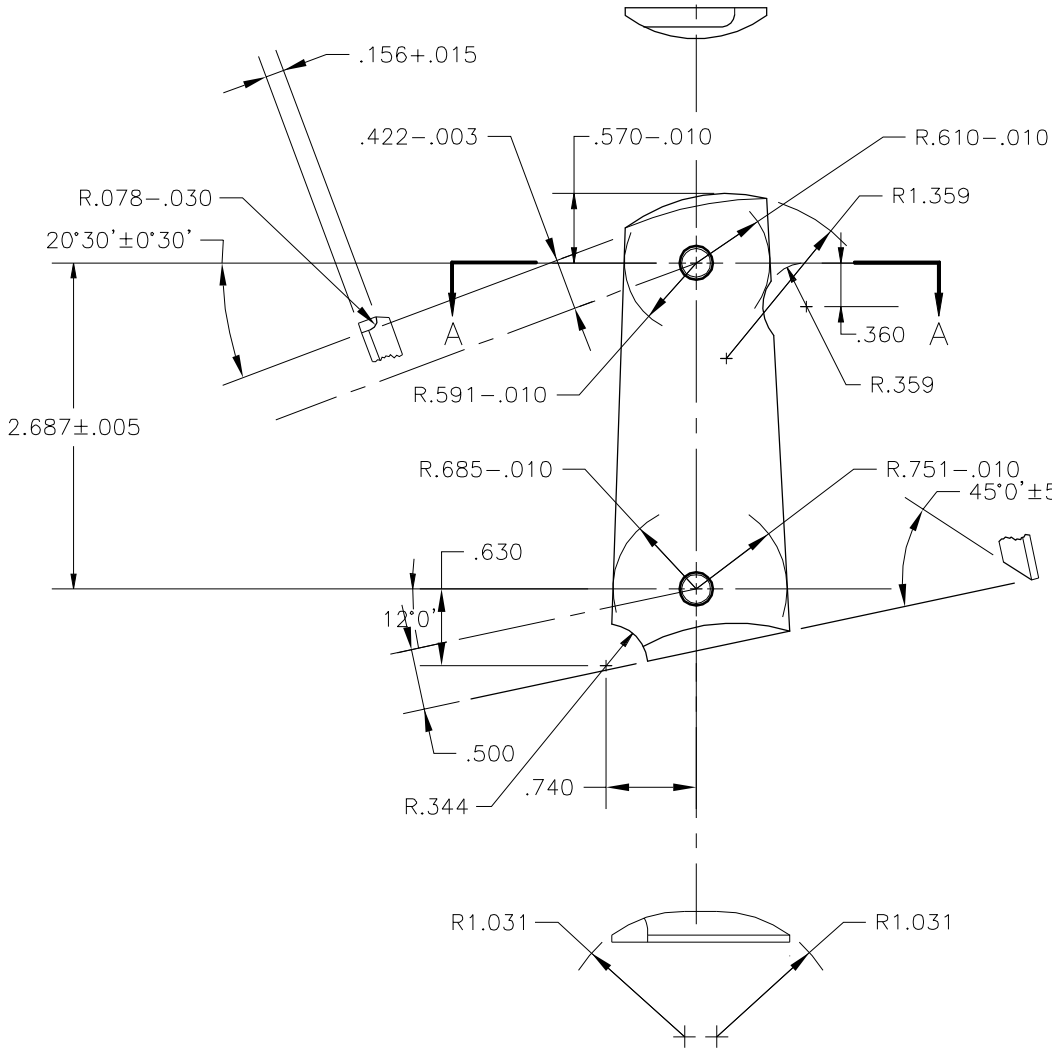
SIZE	FSCM NO.	DWG NO.	REV
C			
SCALE 1:1		SHEET 1 OF 1	

NOTES:

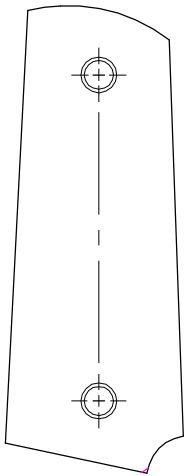
1. AT DIFFERENT TIMES, THE COLT FACTORY HAS USED GRIPS (STOCKS) OF SMOOTH WALNUT, CHECKERED WALNUT, CHECKERED COCOBOLO, RBBER GRIPS BY PACHMAYR WITH INTEGRAL FRONT STRAP, OR BY HOGUE WITH INTEGRAL FRONT STRAP.
2. FOR CLARITY, DRAWING IS BASED ON SMOOTH SURFACE STOCKS IN ORDER TO BETTER ILLUSTRATE DIMENSIONS.



SECTION A-A



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/64

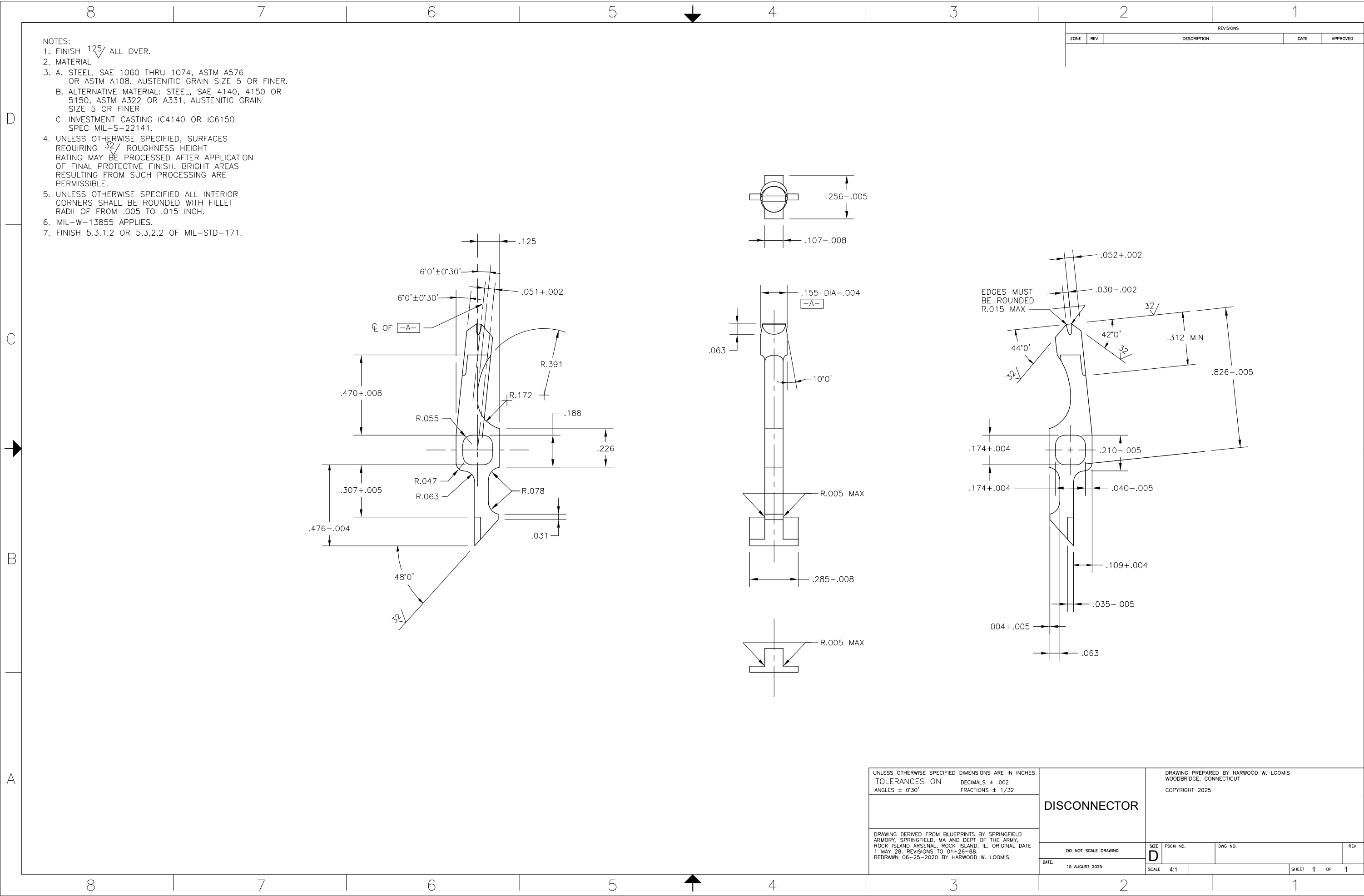
DRAWING DERIVED FROM BLUEPRINTS BY ROCK ISLAND ARSENAL, ROCK ISLAND, IL, AND DEPT OF THE ARMY, ORIGINAL DATE 15 JAN 36. REDRAWN AND REVISED THROUGH 7 OCT 76.

REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**STOCK,
RIGHT HAND,
WALNUT**

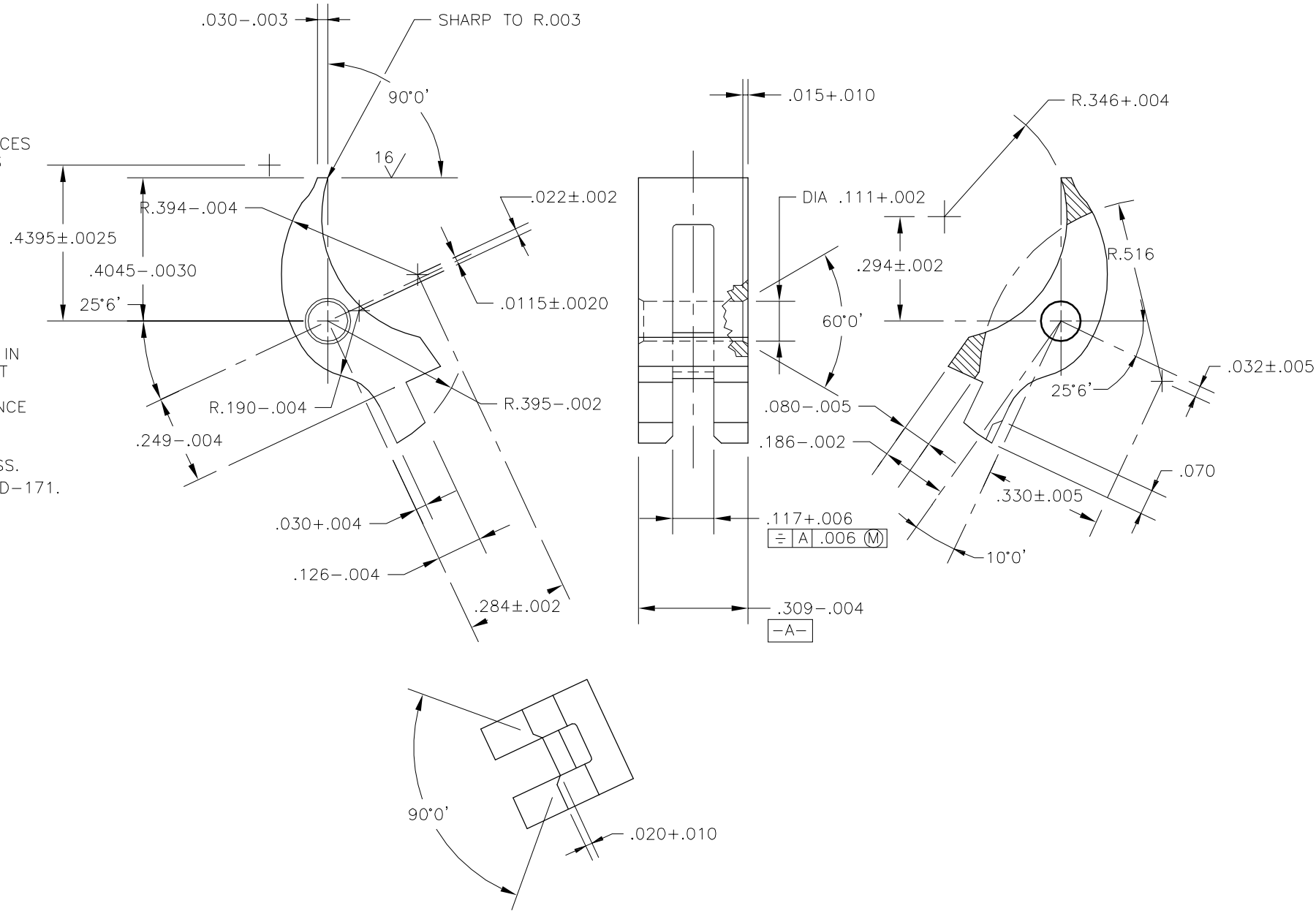
DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

DO NOT SCALE DRAWING	SIZE C	FSCM NO.	DWG NO.	REV
DATE: 15 AUGUST 2025	SCALE 1:1		SHEET 1	OF 1



NOTES:

1. FINISH $125\sqrt{\text{ }}$ ALL OVER.
2. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .0015 INCH.
3. ALL EDGES SHALL BE BROKEN .005 MAX UNLESS OTHERWISE SPECIFIED
4. MATERIAL:
 - A. STEEL, SAE 1060 THRU 1080 PER ASTM A576, A675, OR ASTM A108. A576, OR ASTM A108.
 - B. STEEL, SAE 4150 PER ASTM A304, A322, OR A331.
 - C. INVESTMENT CASTING IC4140 SPEC MIL-S-22141.
5. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING $32\sqrt{\text{ }}$ AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE. APPLY OIL PER VV-L-800 TO BRIGHT AREAS.
6. HEAT TREATMENT:
 - A. STEEL, SAE 1060 THRU 1080 AND 4150 HEAT AT 1540° TO 1580° IN A NEUTRAL ATMOSPHERE. QUENCH IN WELL-AGITATED AUSTEMPERING SALT TO SPECIFIED HARDNESS. HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY.
 - B. INVESTMENT CASTING 4150 STEEL, AUSTEMPER TO REQUIRED HARDNESS.
7. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
8. MIL-W-13855 APPLIES.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 15 DEC 55. REDRAWN BY PICATINNY ARSENAL WITH REVISIONS TO 02-24-92.
REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

SEAR

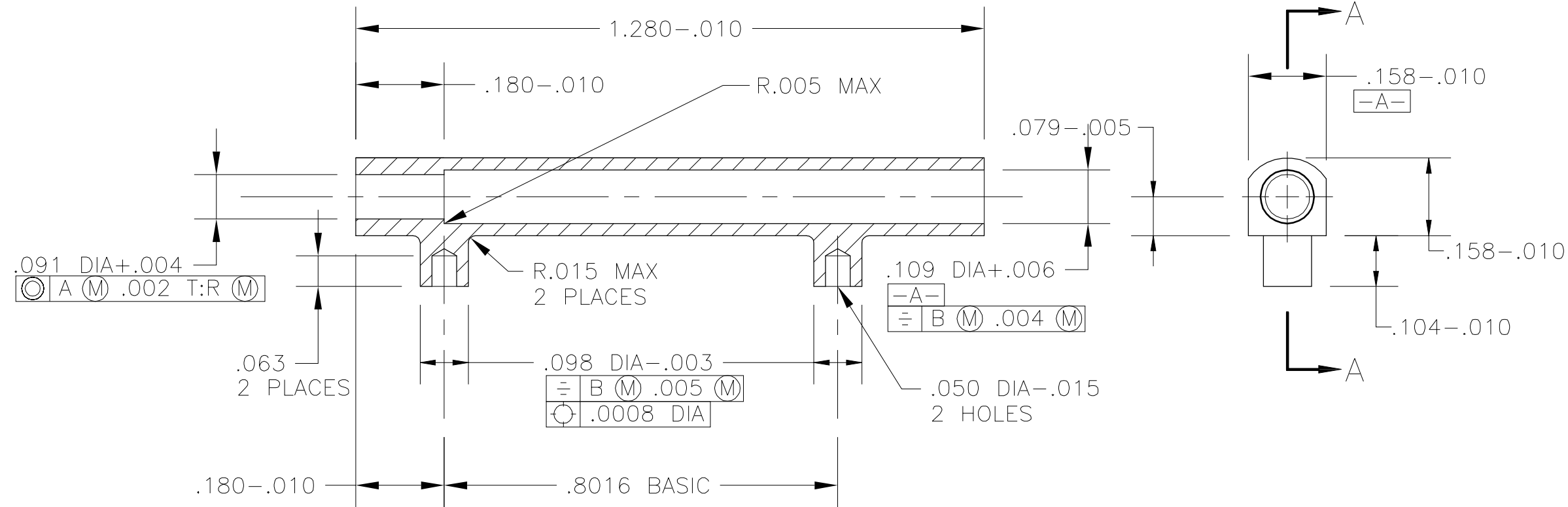
DRAWING PREPARED BY HARWOOD W. LOOMIS
P.O. BOX 323, SEYMOUR, CT 06483
COPYRIGHT 2020

DO NOT SCALE DRAWING	SIZE C	FSCM NO.	DWG NO.	REV
DATE: 08 JULY 2020	SCALE 4:1		SHEET 1	OF 1

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. STEEL, SAE 1017 THRU 1025, ASTM A576
OR STEEL, SAE 1117 OR 1118, ASTM A108
- 3. FINISH 5.3.2.2 OF MIL-STD-171.
- 4. MIL-W-13855 APPLIES.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

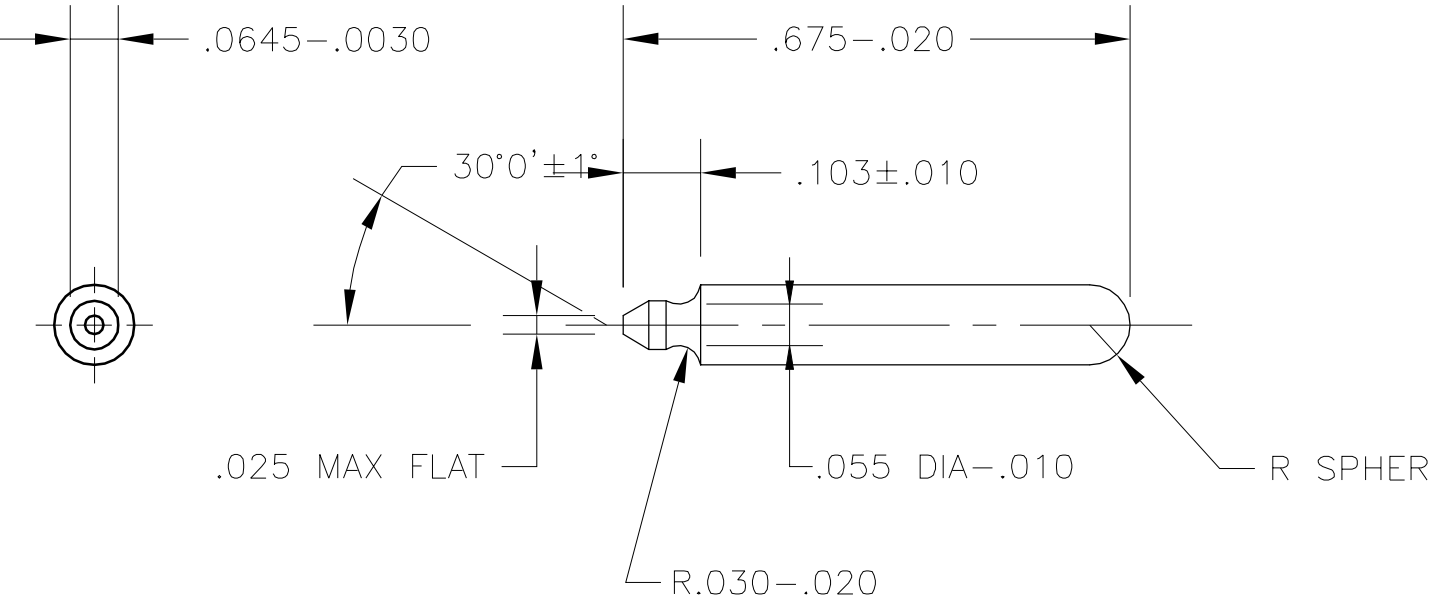


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64	TUBE, PLUNGER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT		
		COPYRIGHT 2025		
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.
	DATE: 15 AUGUST 2025	SCALE 4:1	SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350° F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MATERIAL: STEEL, CARBON, SAE 1018 THRU 1020, 1117. ASTM A108 OR ASTM A576.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.1.2 OF MIL-STD-171.

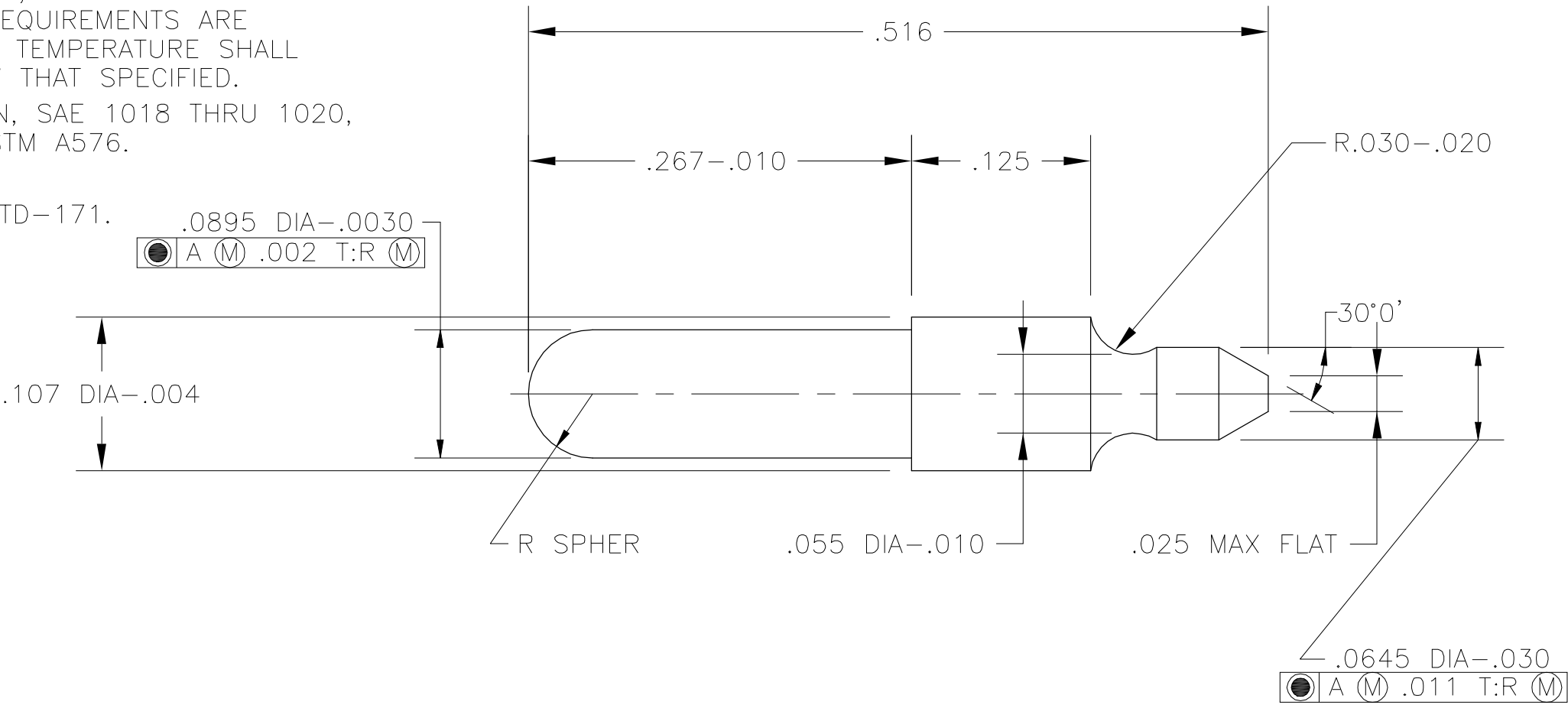
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64	PLUNGER, SAFETY LOCK	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBRIDGE, CONNECTICUT COPYRIGHT 2025			
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE 4:1		SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350° F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 3. MATERIAL: STEEL, CARBON, SAE 1018 THRU 1020, 1117. ASTM A108 OR ASTM A576.
- 4. MIL-W-13855 APPLIES.
- 5. FINISH 5.3.1.2 OF MIL-STD-171.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
 FRACTIONS ± 1/64
ANGLES ± 0°30'

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.

REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**PLUNGER,
SLIDE STOP**

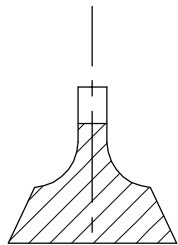
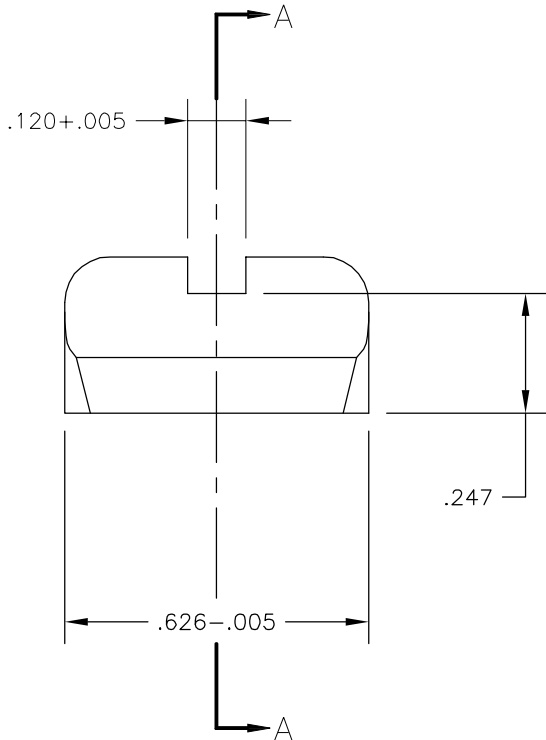
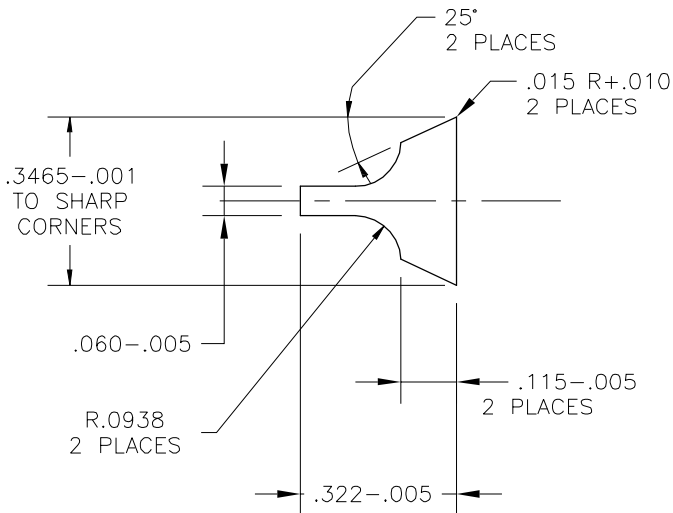
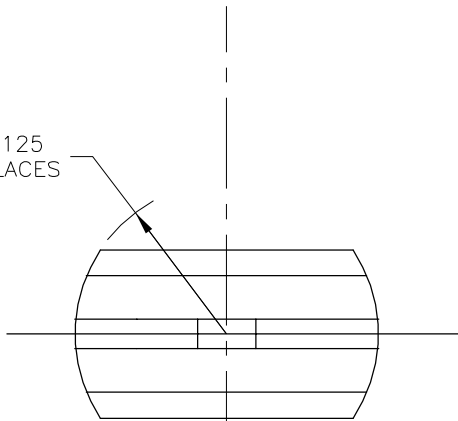
DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.	REV
DATE: 15 AUGUST 2025		SCALE 10:1		SHEET 1	OF 1

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED
2. ALL EDGES SHALL BE BROKEN $.005+.010$ UNLESS OTHERWISE SPECIFIED.
3. FINAL PROTECTIVE FINISH:—FINISH 5.3.1.2 OR 5.3.2.2 OF MIL—STD—171.
4. ALTERNATIVE MATERIAL "INVESTMENT CASTING IC8620, SPEC MIL—S—22141."
5. "INSPECT CASTINGS PER MIL—STD—2175 CLASS 3, GRADE C."

R.3125
2 PLACES



SECTION A-A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. SPRINGFIELD ARMORY REVISIONS TO 2-10-75. ROCK ISLAND ARSENAL REVISIONS TO 10-21-93. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**SIGHT,
REAR**

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

DO NOT SCALE DRAWING

DATE: 15 AUGUST 2025

SIZE
C

FSCM NO.

DWG NO.

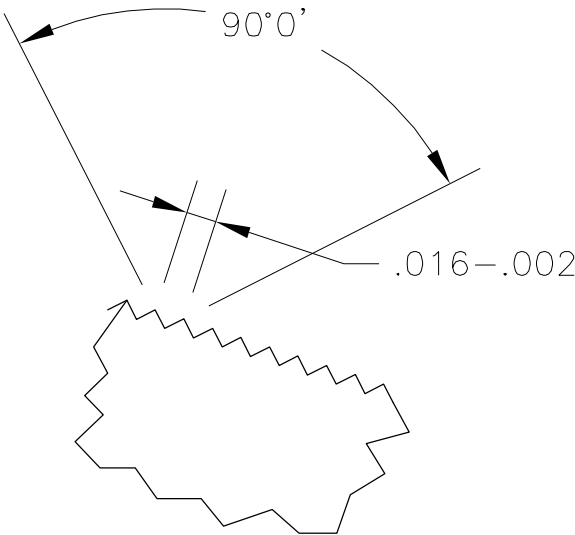
REV

SCALE 4:1

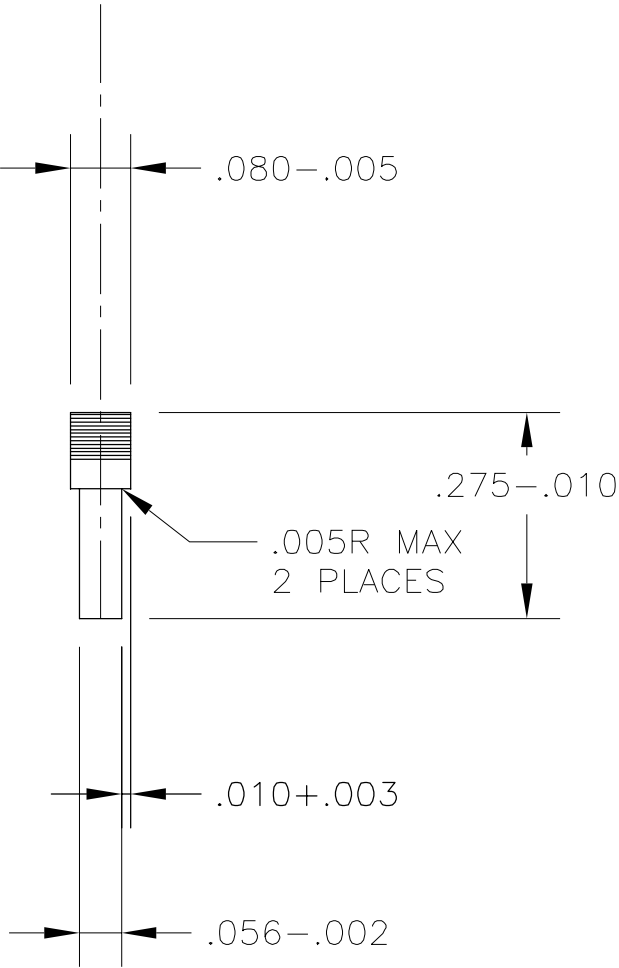
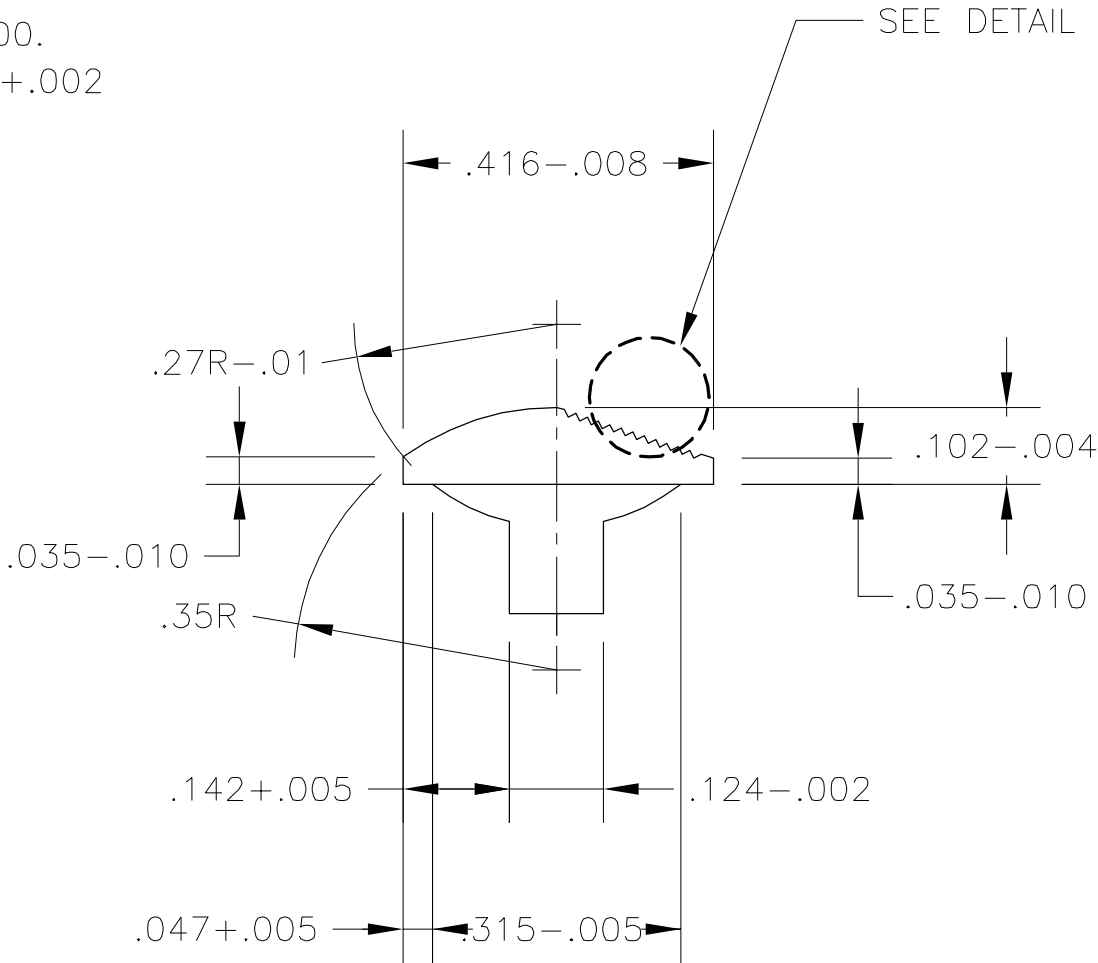
SHEET 1 OF 1

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. STEEL, COMP 1015 THRU 1020,
SPEC QQ-S-698 OR ASTM A108
OR
STEEL, COMP 1025, SPEC QQ-S-700.
- 3. ALL EDGES SHALL BE BROKEN .003+.002
- 4. MIL-W-13855 APPLIES.
- 5. FINAL PROTECTIVE FINISH:
USE FINISH 5.3.1.2 OR 5.3.2.2
OF MIL-STD-171



DETAIL A
SCALE 10/1

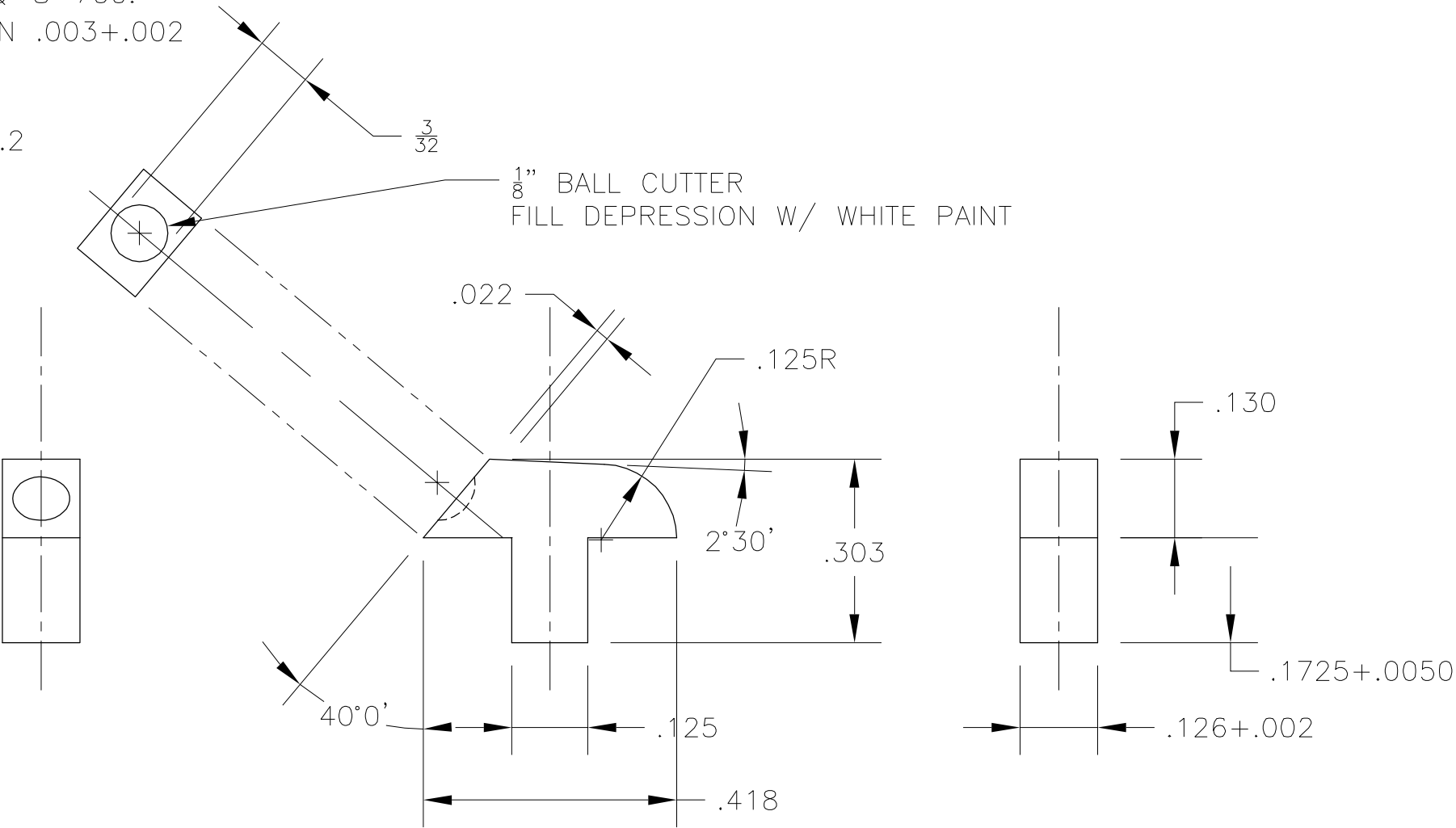


REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/64		DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT COPYRIGHT 2025	
DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS		SIGHT, FRONT, ORIGINAL	
		DO NOT SCALE DRAWING	
DATE: 15 AUGUST 2025		SIZE B	FSCM NO.
		DWG NO.	REV
SCALE 4:1		SHEET 1 OF 1	

NOTES:

- 1. FINISH 125/ ALL OVER.
- 2. STEEL, COMP 1015 THRU 1020,
SPEC QQ-S-698 OR ASTM A108
OR
STEEL, COMP 1025, SPEC QQ-S-700.
- 3. ALL EDGES SHALL BE BROKEN .003+.002
- 4. MIL-W-13855 APPLIES.
- 5. FINAL PROTECTIVE FINISH:
USE FINISH 5.3.1.2 OR 5.3.2.2
OF MIL-STD-171



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .002
ANGLES ± 0°30' FRACTIONS ± 1/64

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD
ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY,
ORIGINAL DATE 1 MAY 28. REDRAWN AND REVISED BY
PICATINNY ARSENAL, NJ, WITH REVISIONS TO 06-21-87.

REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO
OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

**SIGHT,
FRONT,
NEW**

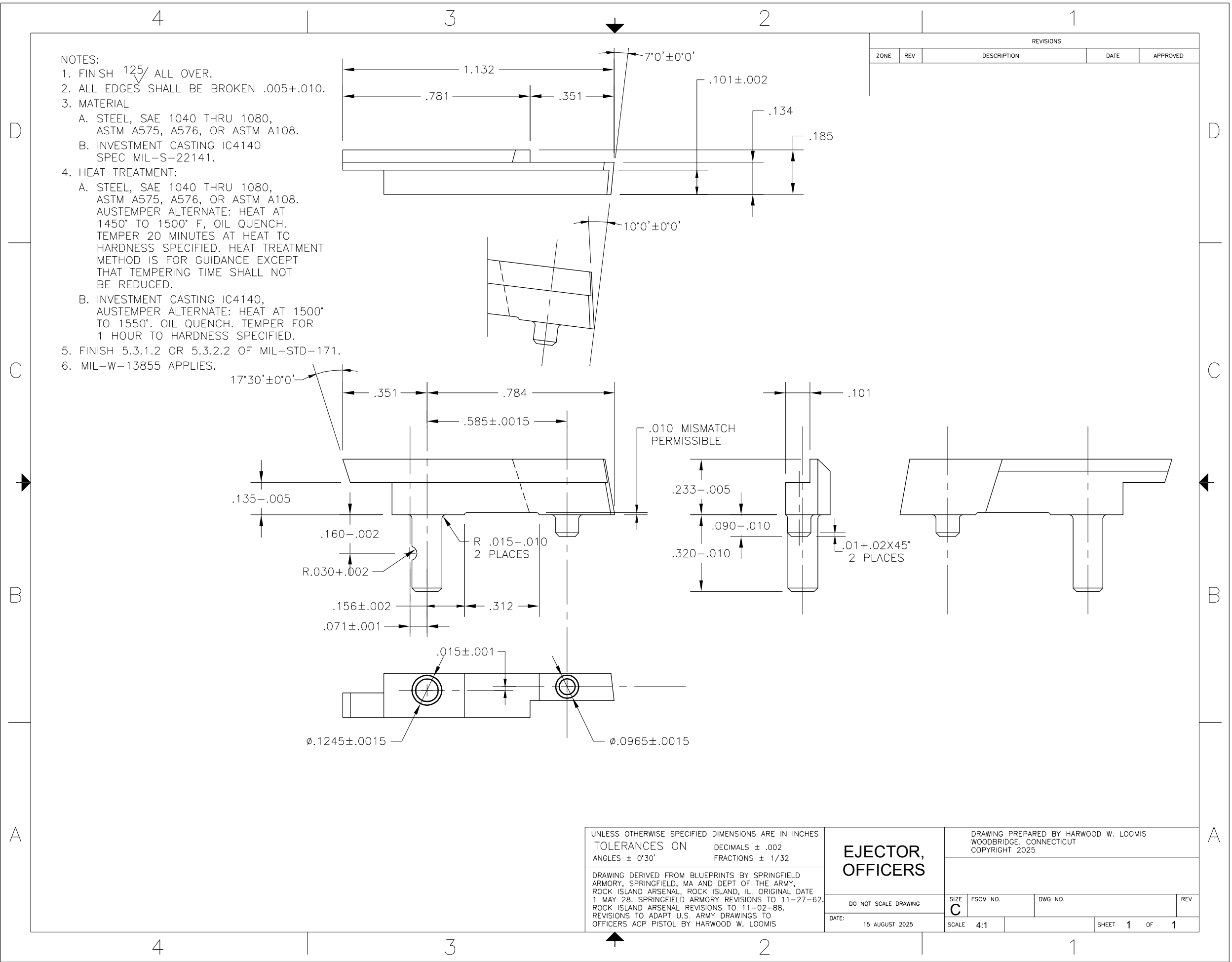
DO NOT SCALE DRAWING

DATE: 15 AUGUST 2025

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT

COPYRIGHT 2025

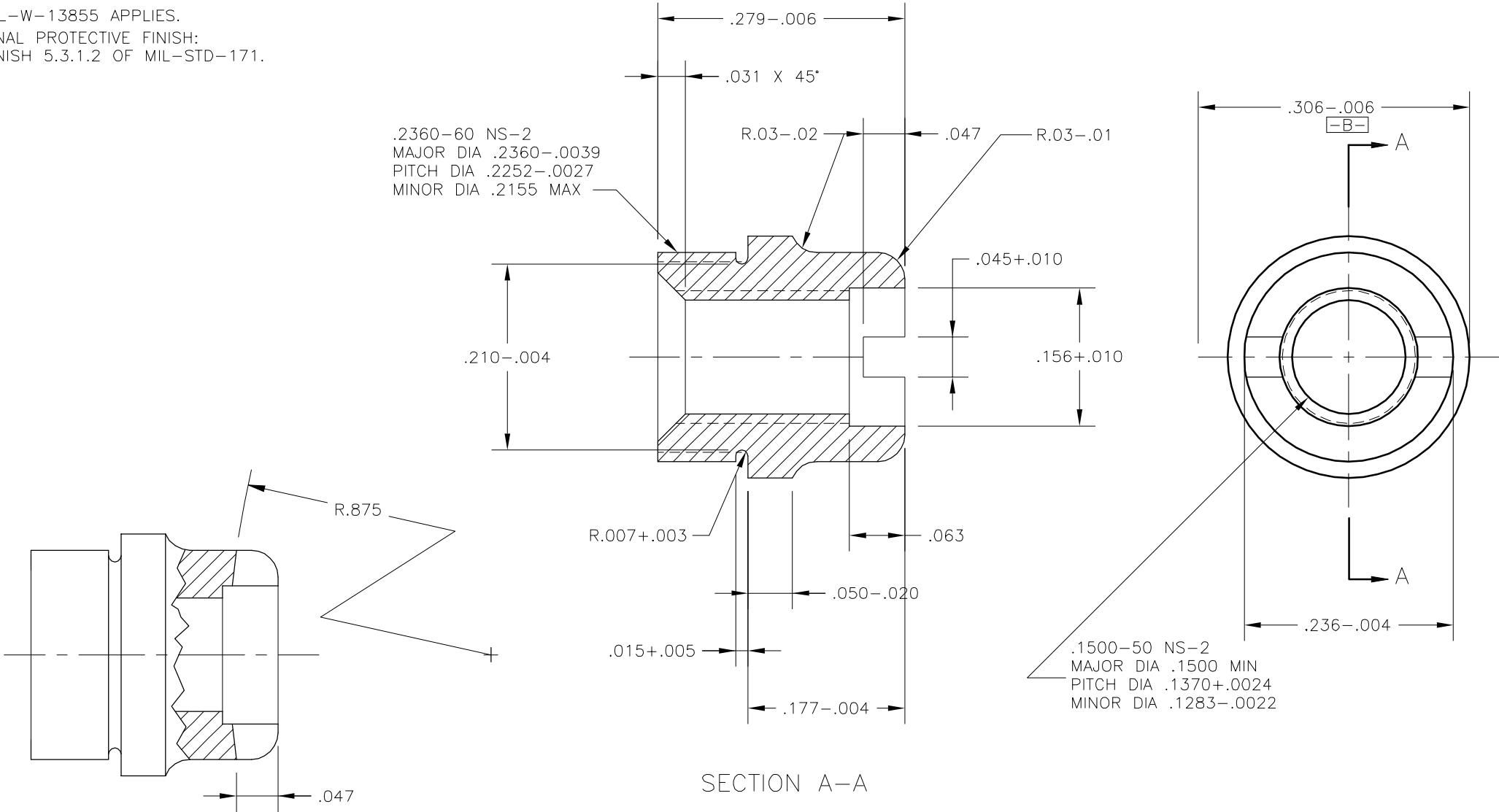
SIZE	FSCM NO.	DWG NO.	REV
B			
SCALE	4:1		
SHEET	1	OF	1



NOTES:

1. FINISH $125\sqrt{\text{ALL OVER}}$.
2. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .0015 INCH.
3. STEEL, CARBON: SAE 1020, 1116, 1117 ASTM A576 OR A108.
4. MIL-W-13855 APPLIES.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
 FRACTIONS $\pm 1/32$
ANGLES $\pm 0^{\circ}30'$

DRAWING DERIVED FROM BLUEPRINTS BY SPRINGFIELD ARMORY, SPRINGFIELD, MA AND DEPT OF THE ARMY, ROCK ISLAND ARSENAL, ROCK ISLAND, IL. ORIGINAL DATE 1 MAY 28. SPRINGFIELD ARMORY REVISIONS TO 11-27-62. ROCK ISLAND ARSENAL REVISIONS TO 11-02-88. REVISIONS TO ADAPT U.S. ARMY DRAWINGS TO OFFICERS ACP PISTOL BY HARWOOD W. LOOMIS

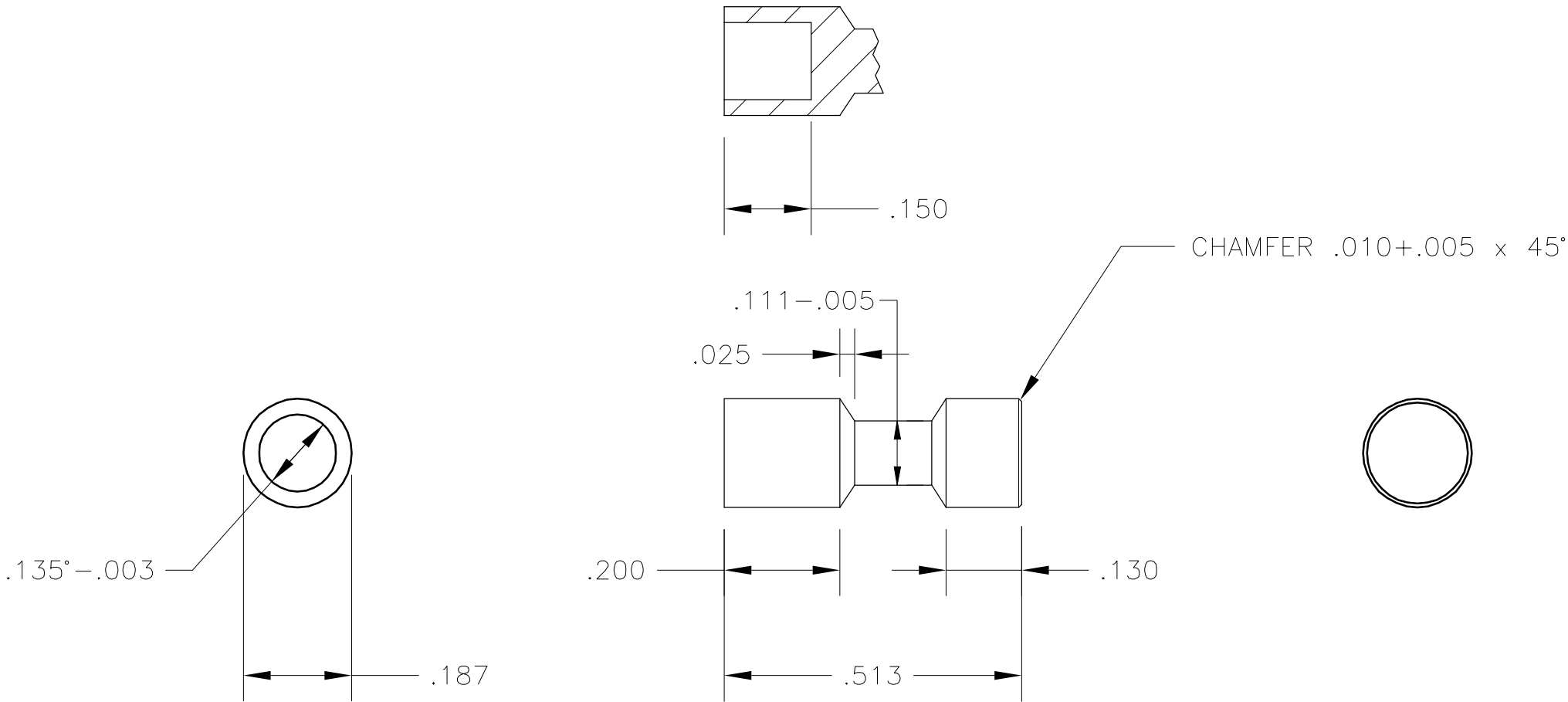
**BUSHING,
STOCK
SCREW**

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT
COPYRIGHT 2025

DO NOT SCALE DRAWING		SIZE C	FSCM NO.	DWG NO.	REV
DATE: 15 AUGUST 2025	SCALE 10:1			SHEET 1	OF 1

NOTES:
1. ALL EDGES SHALL BE BROKEN .005+.010
UNLESS OTHERWISE SPECIFIED.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	FIRING PIN SAFETY PLUNGER SERIES 80	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT		
		COPYRIGHT 2025		
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.
	DATE: 15 AUGUST 2025	SCALE 4:1	SHEET 1 OF 1	



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

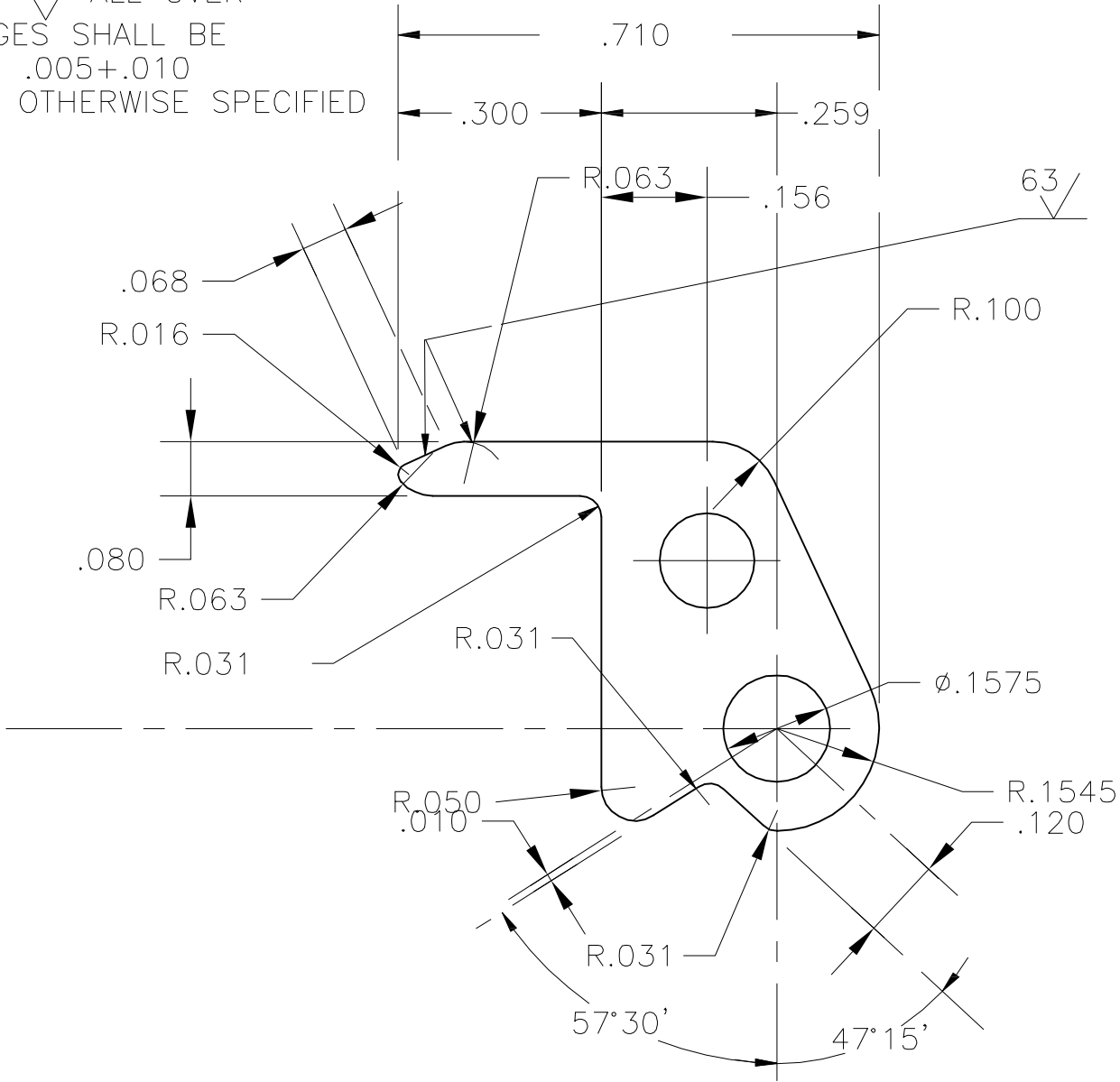
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COIL DIAMETER (OO) ----- .125+.003
FREE LENGTH ----- .375
ACTIVE COILS ----- 9
TOTAL COILS ----- 10
DIRECTION OF HELIX ----- XX
LOAD AT COMPRESSED LENGTH OF ----- XX
LOAD AT COMPRESSED LENGTH OF ----- XX
SPRING RATE ----- XX
SOLID LENGTH ----- .125
TYPE OF ENDS ----- CLOSED



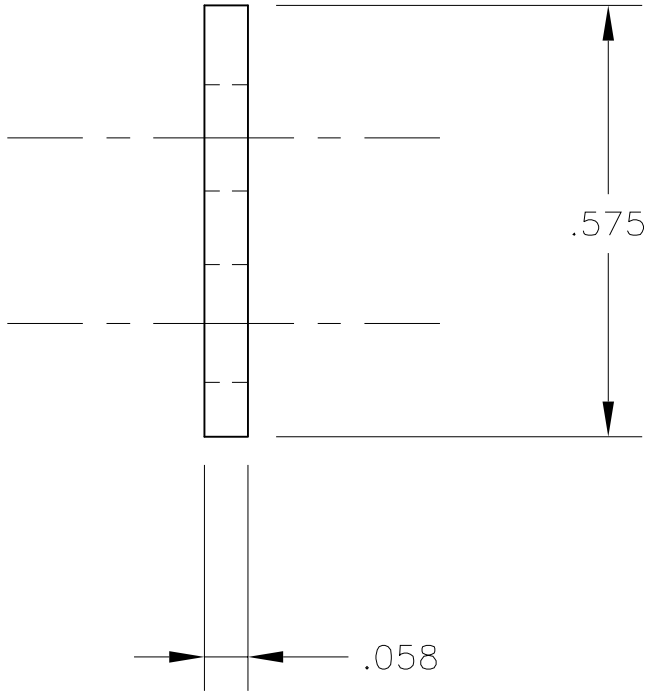
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 FRACTIONS ± 1/32	FIRING PIN PLUNGER SPRING SERIES 80	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT			
		COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING	SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025	SCALE		SHEET 1 OF 1	



NOTES:
1. FINISH 125/ ALL OVER
2. ALL EDGES SHALL BE
BROKEN .005+.010
UNLESS OTHERWISE SPECIFIED

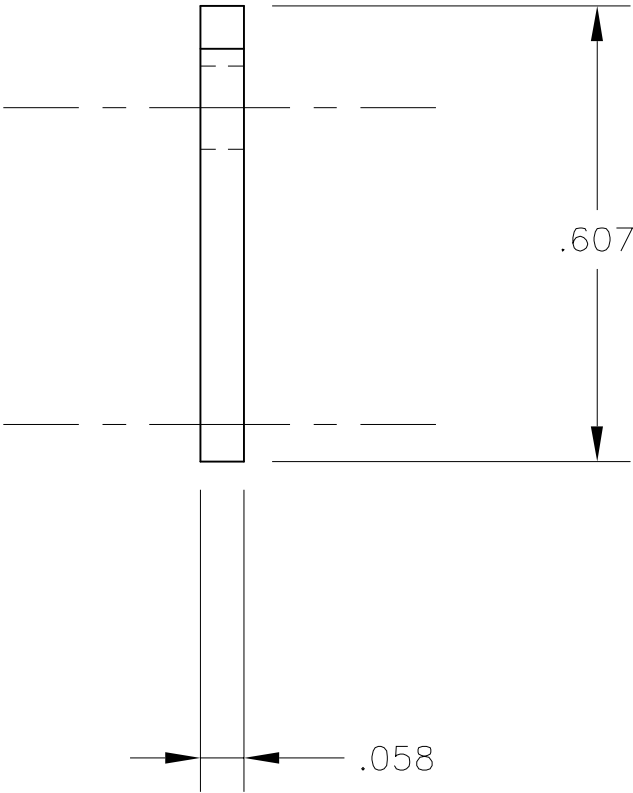
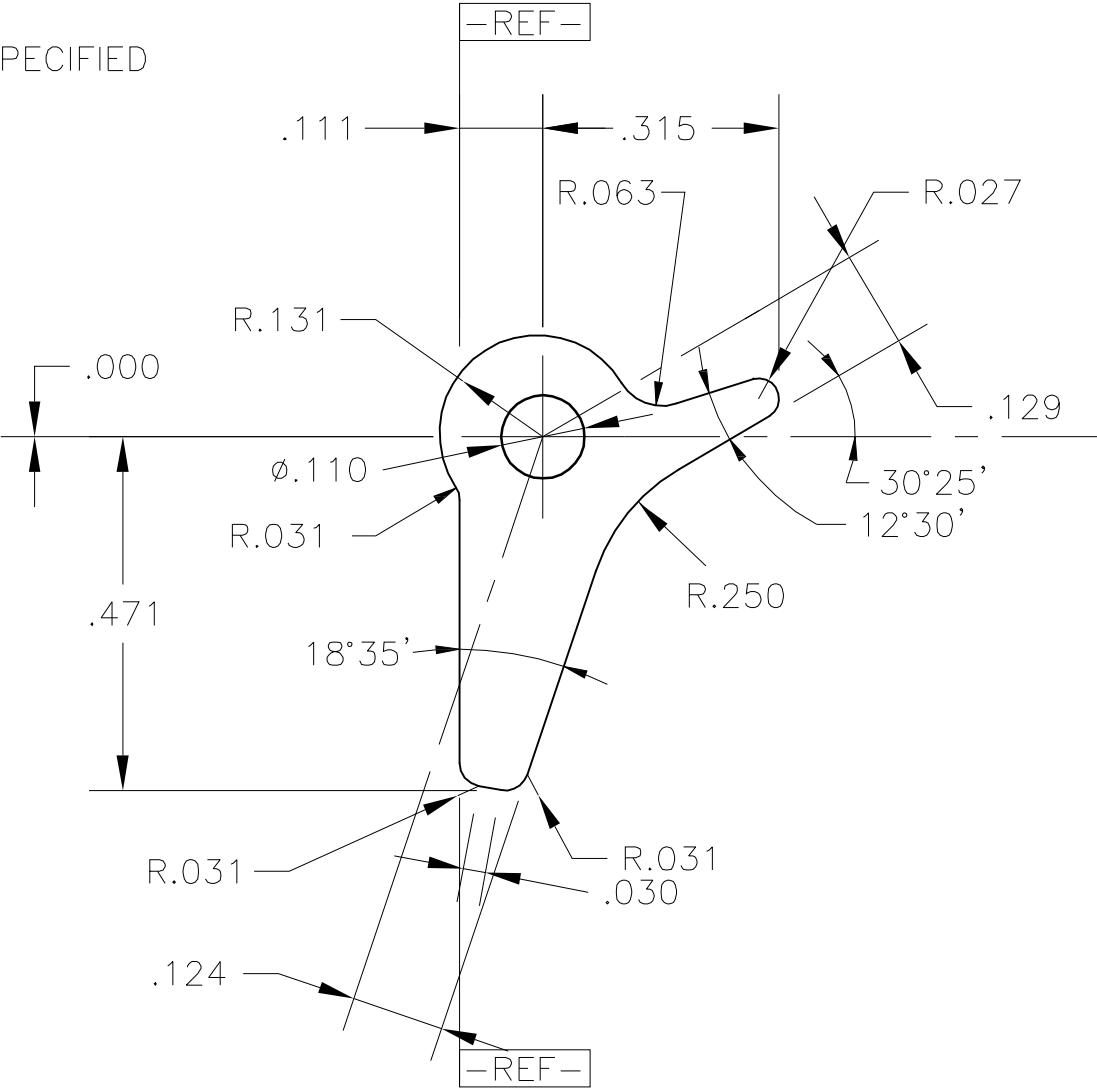


REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/32	LEVER, PLUNGER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBIDGE, CONNECTICUT			
		COPYRIGHT 2025			
	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DATE: 15 AUGUST 2025		SCALE 4:1	SHEET 1 OF 1	
					REV

NOTES:
1. FINISH 125/ ALL OVER
2. ALL EDGES SHALL BE
BROKEN .005+.010
UNLESS OTHERWISE SPECIFIED



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS $\pm .002$
ANGLES $\pm 0^{\circ}30'$ FRACTIONS $\pm 1/32$

THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY
DRAWINGS FOR THIS PART.
DRAWING CREATED FROM MEASUREMENTS OF ACTUAL
PARTS BY HARWOOD W. LOOMIS

LEVER,
TRIGGER

DO NOT SCALE DRAWING

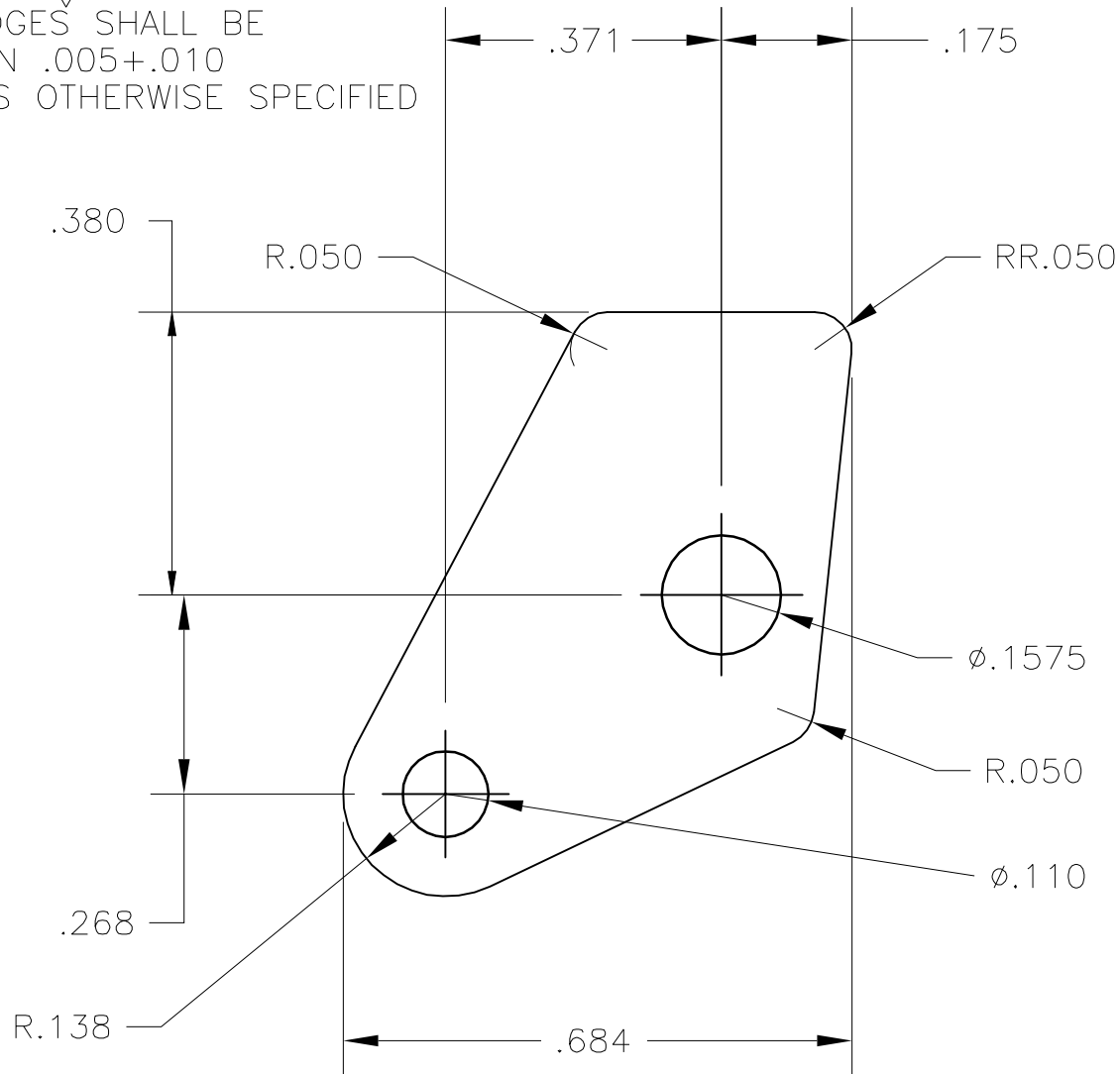
DATE: 15 AUGUST 2025

DRAWING PREPARED BY HARWOOD W. LOOMIS
WOODBIDGE, CONNECTICUT

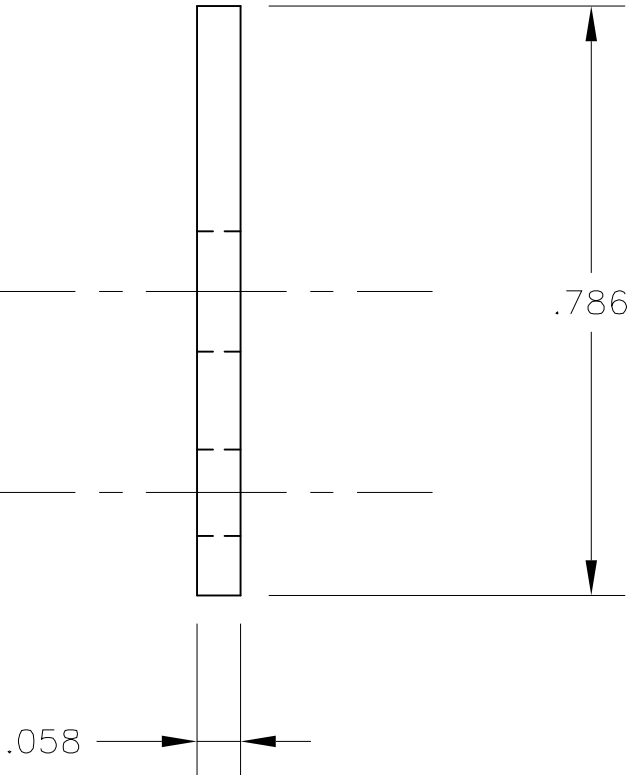
COPYRIGHT 2025

SIZE	FSCM NO.	DWG NO.	REV
B			
SCALE 4:1		SHEET 1 OF 1	

- NOTES:
- 1. FINISH 125/ ALL OVER
 - 2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED

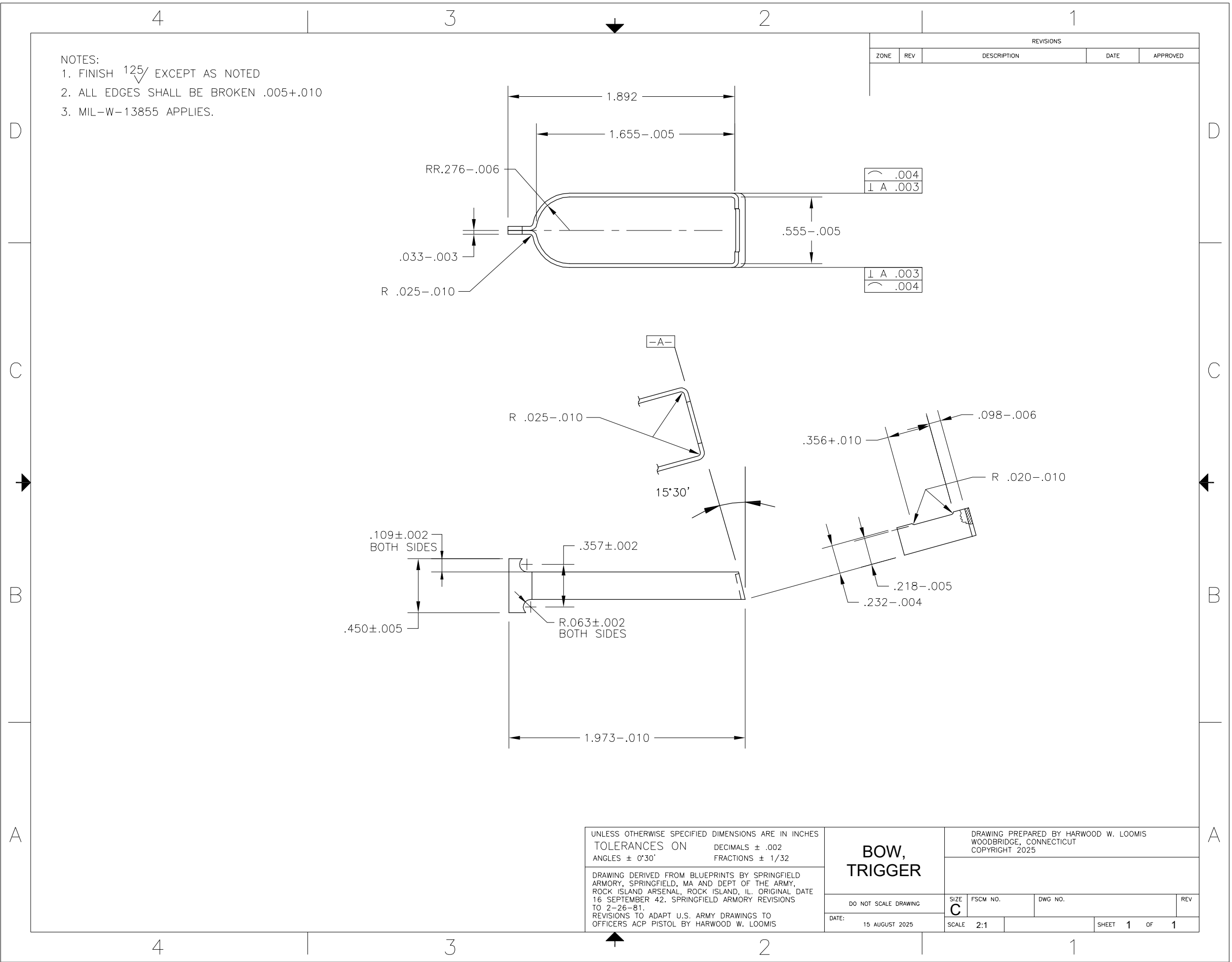


REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

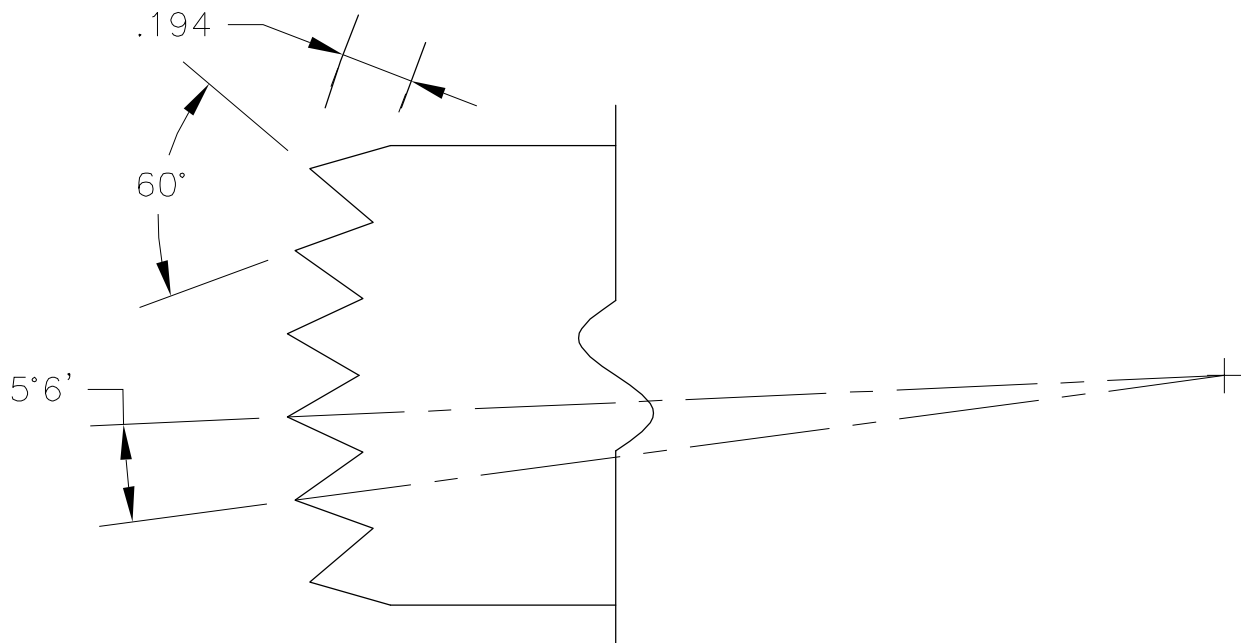


NOTE:
FOR USE WHEN INSTALLING
A NON-SERIES 80 SLIDE
ASSEMBLY ON A SERIES 80
RECEIVER

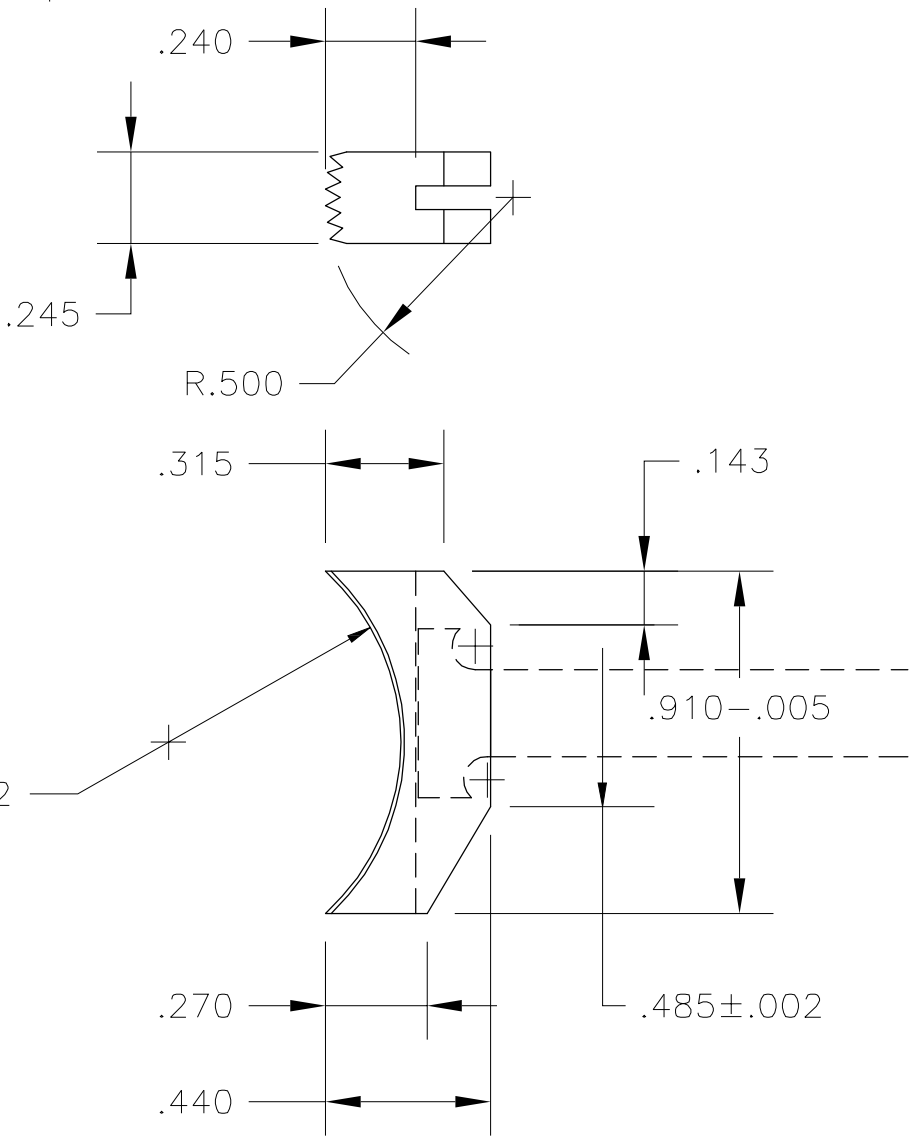
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/32		SHIM, FRAME SPACER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBRIDGE, CONNECTICUT COPYRIGHT 2025			
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS	DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.	REV
	DATE: 15 AUGUST 2025		SCALE 4:1			SHEET 1 OF 1



- NOTES:
- 1. FINISH $125\sqrt{}$ EXCEPT AS NOTED
 - 2. ALL EDGES SHALL BE BROKEN .005+.010
 - 3. MIL-W-13855 APPLIES.



SERRATION DETAIL
SCALE 10:1



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .002 ANGLES ± 0°30' FRACTIONS ± 1/32		PAD, TRIGGER	DRAWING PREPARED BY HARWOOD W. LOOMIS WOODBRIDGE, CONNECTICUT COPYRIGHT 2025				
THERE ARE NO ORDNANCE DEPARTMENT OR U.S. ARMY DRAWINGS FOR THIS PART. DRAWING CREATED FROM MEASUREMENTS OF ACTUAL PARTS BY HARWOOD W. LOOMIS		DO NOT SCALE DRAWING		SIZE B	FSCM NO.	DWG NO.	REV
		DATE: 15 AUGUST 2025		SCALE 2:1		SHEET 1 OF 1	